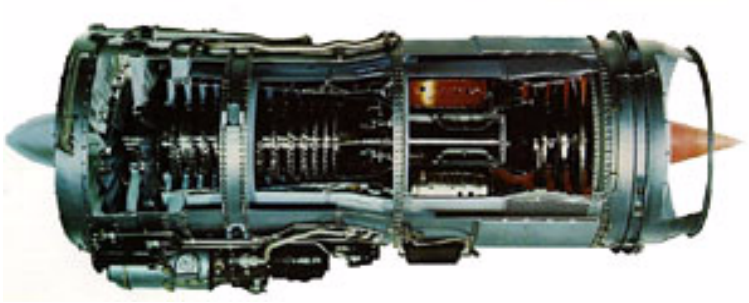
NAVY / AIR FORCE
DEPOT LEVEL ENGINE SPECIFICATION

JT8D MODEL
TURBOFAN ENGINE

JT8D Standard Engine



THIS PUBLICATION SUPERSEDES THE JOINT NAVY / AIR FORCE JT8D-9A OVERHAUL AND HSI SPECIFICATIONS DATED 01 February 2000 AND ALL SUBSEQUENT CHANGES, WHICH SHOULD BE DESTROYED.

PUBLISHED BY NAVAIR PROGRAM MANAGER AIR 207 IN CONJUNCTION WITH OC-ALC/LKKA

REVISION 1
01 OCTOBER 2004

C-9 JT8D DEPOT LEVEL ENGINE SPECIFICATION
LIST OF CHANGES

CHANGE NO.	INSERTION DATE	BY	CHANGE NO.	INSERTION DATE	BY	CHANGE NO.	INSERTION DATE	BY

REVISION 1
01 OCTOBER 2004

C-9/JT8D DEPOT LEVEL ENGINE SPECIFICATION
SECTION I. GENERAL

1.0 SCOPE

1.1 **Scope.** This specification establishes the Joint Navy/Air Force requirements for Depot Level Maintenance of the C-9 aircraft's Pratt & Whitney JT8D engine. The specification provides requirements for scheduled and unscheduled Engine Shop Visits (ESV's), field team repair and inspection of engines, incorporation of manufacturers Service Bulletins and management of an Engine Condition Monitoring (ECM) Program.

1.2 **Scheduled Engine Shop Visits .** Engines are periodically scheduled for two major inspections, ESV-1 and ESV-2. ESV-1 is scheduled every 6,300/7,000 hours plus ten percent since last ESV 2. ESV-2 is scheduled every 12,000/13,200 hours plus ten percent since last ESV-2. If conditions warrant, ESV-1 or 2 may be accomplished prior to the scheduled time. Scheduled ESV's provide for thorough and comprehensive inspection and repair of the gas generator, components and accessories, and compliance with routine and FAA mandated Service Bulletins.

1.3 **Unscheduled Engine Shop Visits.** Unscheduled Engine Shop Visits are accomplished when repair requirements are beyond Organizational Level repair capability. Depot level repairs may be accomplished on-wing by a field team or the engine may be removed to the shop when conditions warrant. The decision to repair an engine on-wing or remove the engine to the shop shall be based on an assessment between the Government and the engine contractor performing the repairs. Additional repair or work requirements, beyond those for which the engine was inducted, shall only be accomplished upon approval by the C-9 Program Management Office via the ACO.

2.0 GENERAL REQUIREMENTS

2.1 **Certification.** The contractor shall possess and maintain a current FAA approved repair station certificate, rated specifically for the JT8D engine. Personnel performing maintenance, tests, inspections, etc., shall be FAA certified and qualified on the JT8D series engine. The contractor shall ensure subcontractors accomplishing component inspection or repair, possess and maintain a current FAA approved Repair Station Rating as applicable for the type of work being accomplished.

2.2 **Specification Changes/Technical Guidance.** When issued by Pratt & Whitney and the Federal Aviation Administration (FAA), Service Bulletins, Airworthiness Directives and any revisions thereof, shall be reviewed by the Contractor for applicability to Navy and Air Force engines. The Contractor shall provide recommendations of compliance/non-compliance to the Navy and Air Force C-9 Program Management Offices. Revisions and changes, including Interim Change Notices (ICN's), to this specification, will be issued as necessary to ensure maintenance requirements are maintained in a current and effective status. Revisions and changes will be issued by the applicable program office via the PCO. Technical questions, problems or recommendations concerning this specification, should be directed to the applicable program management office:

C-9 JT8D DEPOT LEVEL ENGINE SPECIFICATION
DISTRIBUTION LIST

ORGANIZATION AND ADDRESS	NUMBER OF COPIES
NAVAL AIR SYSTEMS COMMAND PMA-207 46990 HINKLE CIRCLE UNIT 8 PATUXENT RIVER, M D 20602	1
OC-ALC/LKKA 3001 STAFF DRIVE SUITE 1AG1105A TINKER AFB, OK 73145-3018	2
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	OR
(Air Force)	OC-ALC/LKKA 3001 Staff Drive, STE 1AG110 Tinker AFB, OK 73145-3018

2.3 **Technical Reviews.** An Engine Specification technical review shall be held at the contractor's site annually, or at any time if conditions warrant.

2.4 **Applicable Maintenance Documents.** Work accomplished to meet the requirements of this specification shall be done in accordance with applicable OEM manuals. Service Bulletins, Field Notes, All Operators Letters, etc., and applicable FAA regulations. The contractor shall ensure the latest change and revision information is incorporated into these documents.

2.5 **Engine Applicability.** The requirements of this specification apply to the following JT8D-9A engines.

2.5.1 **Navy/Marine Engines.**

653509	653699	656975	657201	**657591**	657650
657699	657714	665566	666661	666778	666804
666874	666890	666914	666918	667050	667055
667056	667057	667058	667060	667065	667066
667067	667069	667070	667071	667073	667121
667128	667129	667130	667131	**667135**	667138
667139	667141	667142	**667144**	667146	667148
667149	667172	667203	667204	**667216**	667232
667233	**667244**	667245	674547		

"Marine Engine Serial Numbers are in "Bold"

2.5.2 **Air Force Engines.**

655848	666655	666660	666679	666685	666720
666728	666730	666738	666748	666764	666770
666781	666801	666849	666853	666860	666878
666879	666977	666980	666990	666991	666992
667007	667008	667010	667016	667119	667126
674370	687804				

2.6 **Definitions and Acronyms.**

2.6.1 **Definitions**.

Check, Bench	In-shop test using calibrated test equipment, to determine if component operating parameters meet component overhaul manual specifications.
Check, Functional	The exercise of a component within its operating modes, to assure operation without interference and in proper direction and sequence of intended performance. Normal operation is verified through observation of overall performance without resort to measurement.
Condition	To inspect for (condition) as used herein implies a visual examination to determine the existence of external damage and defects that could render the article unacceptable for continued use.

Defect	Any nonconformance of a unit or part with specified requirements.
Defect, Critical	A defect that constitutes a hazardous or unsafe condition, or as determined by experience and judgment could conceivably become so, relative to the harmful effect on the prime intended function, safety of flight, or mission capability of the aircraft or its operating personnel.
Defect, Major	A defect, other than critical, that could result in failure, materially reduce, or if not corrected, will degrade the usability of the unit or part for its intended purpose.
Insitu	To accomplish in-place or without disassembly.
Maintenance, Heavy	Procedures used primarily for the disassembly, repair and reassembly of engine sections to accomplish part life exchange or special repairs to various parts or components of the engine while it is removed from the aircraft.
Maintenance, Scheduled	That maintenance performed to retain an item in serviceable condition by systematic inspection, detection, prevention of incipient failures, replacement of worn items, adjustment, calibration, cleaning, testing, etc.
Maintenance, Unscheduled	That maintenance, not previously planned, which is performed to restore an item to a satisfactory condition by providing correction of a know or suspected malfunction and/or defect.
Module	A combination of assemblies, subassemblies and parts, contained in one package, or so arranged as to be replaced in one maintenance action. May also be referred to as a major assembly, assembly group or Major Engine Build Group (MEBG).
Office, C-9 Program Management	The C-9 Program Management Office refers to the Air Force or Navy Office responsible for C-9 Logistics and Engineering.

Overhaul	The complete restoration of an item, or engine, in accordance with the instructions defined in the relevant overhaul manual.

Program, Maintenance	A program which defines a logical sequence of maintenance actions to be performed as events or pieces of a whole which, when performed collectively, result in achievement of the desired maintenance standards.
Removal, Scheduled	Removal of an item as a result of the item's life having approached, or achieved, a previously defined limit.
Removal, Unscheduled	Removal required to facilitate unanticipated repair.

2.6.2 **Acronyms.**

ACO	Administrative Contracting Officer
ASB	Alert Service Bulletin
ASSY	Assembly
AD	Airworthiness Directive
ALC	Air Logistics Center
CSD	Constant Speed Drive
DER	Designated Engineering Representative
EGT	Engine Exhaust Temperature
EB	Electron Beam
EO	Engineering Order
FCU	Fuel Control Unit
FIR	Full Indicator Reading
FOD	Foreign Object Damage
FPI	Fluorescent Penetrant Inspection
HPC	High Pressure Compressor
ICC	Intermediate Compressor Case
ID	Inside Diameter
JOAP	Joint Oil Analysis Program
LPC	Low Pressure Compressor
MEBG	Major Engine Build Group
MPI	Magnetic Particle Inspection]
NDT	Non-Destructive Test
NGV	Nozzle Guide Vane
OHM	Overhaul Manual
OD	Outside Diameter
PCW	Previously Complied With
P&D	Pressurization and Dump
P/N	Part Number
PMA	Program Manager Air
PRBC	Pressure Ratio Bleed Control
PW	Pratt & Whitney

PWA	Pratt & Whitney Aircraft
QEC	Quick Engine Change
SB	Service Bulletin
SPOP	Service Process Operation Procedure
TBO	Time Between Overhaul

1.0 GENERAL

1.1 Configuration Management.

1.1.1 **Inventory.** The contractor shall at each shop visit and to the extent of disassembly record part number, and when applicable serial number, of all engine "significant parts", QEC and accessory components removed from the "as received" engine, and upon reassembly, record part number and serial number of the parts installed. (CDRL)

1.1.2 **Appendix A Compliance Codes**. For purposes of this Specification the following compliance codes apply:

Joint Service Requirement	(X)
Navy only Requirement	(XN)
Air Force only Requirement	(XA)

1.1.2.1 **Service Bulletins/Technical Directives.** Appendix C provides SB and Technical Directive requirements. To the extent of disassembly; accomplishment, or verification of accomplishment, of SB, shall be annotated at each engine shop visit. If a SB provides options, the option that was accomplished shall be recorded. Engines shall not be de-configured unless otherwise directed by the ACO. (CDRL)

1.1.2.2 **Alert Service Bulletins.** The contractor shall ensure all Pratt & Whitney ASB and FAA AD's are reviewed for applicability to engines listed in Section I. If the ASB or AD requirements are different from the requirements of this Specification, the contractor shall seek disposition. The contractor shall provide an ASB/AD status report for each engine, to include necessary data for establishing and tracking repetitive inspection intervals at the Organizational level. (CDRL)

1.1.2.3 **Modification Service Bulletins.** SBs that modify the engine, that is, change form, fit or function, shall only be accomplished during ESV-1 or ESV-2, unless otherwise directed by the ACO. Modification SBs shall not be accomplished unless they are listed in the Appendix.

1.1.2.4 **Service Bulletin Compliance Codes.** For purposes of this Specification, the following compliance codes apply:

Attrition (A) - SB shall be accomplished when the part affected is determined to be unserviceable.

Required (R) - SB accomplishment is required. Special remarks may be provided when applicability is related to compliance categories or compliance effectivity.

Mandatory (M) - SB accomplishment is mandatory and must be accomplished. Mandatory compliance is usually associated with an ASB or AD.

Air Force (AF) - SB with designation (AF), apply to Air Force engines.

Navy (N) - SB with designation (N), apply to Navy engines.

1.2 **Maintenance History Data.** The contractor shall at each engine shop visit, and to the extent of disassembly and inspection, record inspection results of engine QEC components, accessories and engine significant parts. (CDRL)

1.3 **Life Limited Parts.**

1.3.1 **Removal Criteria.** Prior to inspection for serviceability, all life-limited parts shall be evaluated for flight hours/cycles remaining. If a part has not reached its life limit, the determination to scrap, inspect, and reinstall, or inspect and hold for future utilization shall be made by the Government and contractor collectively. When evaluating the cost effectiveness of retaining disks in service, factors such as the average inspection and repair costs, and cost to replace at a future date by field team, etc., shall be weighed against the useful life remaining.

1.3.1.1 **C-1 and C-2 Disks.** First and second stage disks shall be fully utilized unless continued operation is determined to be uneconomical. Disks with sufficient time remaining may be removed and held as Customer Owned Property for future utilization.

1.3.1.2 **All Other Disks.** All other serviceable disks shall have sufficient hours/cycles remaining to reach next ESV-2. Disks that do not have sufficient hours/cycles remaining to reach next ESV-2, shall be evaluated individually to determine disposition (that is, disks shall either be scrapped or preserved for future utilization). Disks to be scrapped shall be processed in accordance with contract requirements.

1.3.2 **Future Utilization.** Disk overhaul date, total hours and cycles, type of coating processes used and any inspection due dates shall be clearly annotated on the serviceable tag and tracked by computer program. The utilization of these parts shall be coordinated with and approved by the applicable Navy/Air Force C-9 Program Manager.

1.3.3 **Installed Parts Tracking.** The contractor shall provide the required tracking data for each life-limited part delivered with the engine. (CDRL)

1.4 **Parts Disposition.** Parts, which are beyond repair, or parts which are serviceable or repairable, but are not to be reinstalled due to the requirements of this Specification, shall be disposed of by the contractor and credit provided to the government. The value of the credit shall be approved by the ACO. Life limited parts, which are scrapped, shall be adequately mutilated to preclude future use. Serviceable or repairable parts may be held for Customer Owned Property (COP), as required.

1.4.1 **Customer Owned Property.** A complete inventory, including hours/cycles remaining on all life limited parts, shall be maintained for Customer Owned Property (COP) parts being held for future utilization.

1.5 **Major or Critical Defects.** Defects disclosed during a depot level shop visit, which are considered to be of such a nature as to warrant immediate attention (an urgent or dangerous condition that may exist in other JT8D engines and is sufficient to require an immediate one time inspection) shall be brought to the immediate attention of the Navy and Air Force C-9 Program Managers with a follow-up report.

1.6 **Part/Component Replacement.** When possible, engine parts and components shall be repaired. However, if repair costs are projected to exceed 80% of the cost of a new part or component, it shall be replaced with a new part. The new replacement part shall be the latest, most reliable available that does not change form, fit or function (that is, the part number may be different, but it shall be a direct replacement part with no modifications required).

1.7 **Engine Logbooks.** Prior to induction, the contractor shall review the engine logbook to verify reason for removal and determine if any previously recorded depot level discrepancies exist. The contractor shall seek disposition instructions for discrepancies identified in the logbook, but not specifically mentioned in the work order. The Contractor shall ensure Engine Logbooks are annotated with required information upon completion of work.

1.8 **Shipping and Handling.** Engines shall be shipped and handled in accordance with the Pratt & Whitney Standard Practices Manual No. 585005. When engines are shipped by ground transportation, only vehicles with air suspension, or equivalent "soft" system shall be used. Use of spring type suspension system is not authorized.

1.9 **Engine Preservation.** Unless otherwise directed in the engine work order, the engine shall be preserved to Level IV (90 plus days) in accordance with Pratt & Whitney Manual P/N 481671.

2.0 ENGINE SHOP VISIT REQUIREMENTS (SCHEDULED)

2.1 **Engine Shop Visit No.1 (ESV-1).** When specifically directed by the ACO, the contractor shall accomplish ESV-1 in accordance with the following requirements. Accessory components shall be inspected in accordance with the requirements of Appendix B. QEC items shall be visually inspected.

2.1.1 Preinduction Evaluation.

1. Visually inspect engine exterior, accessories and QEC components for damage, security and leaks.

2. Visually inspect inlet and exhaust areas for evidence of FOD and oil leaks.

3. Inspect N1 for freedom of rotation.

4. Inspect 1st and 2nd stage fan blades for damage.

5. Borescope 6th, 7th and 13th stage compressor blades for damage.

6. Conduct engine performance test and record parameters, as required.

7. Prior to disassembly, provide recommendations, with justification, of additional work required as a result of engine preinduction evaluation.

2.1.2 **Disassembly.** Disassemble engine as required by Appendix A.

2.1.3 **Inspection.** Major Engine Build Group (MEBG) inspection requirements are listed in Appendix A. As a minimum, all exposed parts shall be visually inspected. Refer to Appendix C for a complete listing of SB requirements.

2.2 **Engine Shop Visit No. 2 (ESV-2).** When specifically directed by the ACO, the contractor shall accomplish ESV-2 in accordance with the following requirements. Accessory components shall be inspected in accordance with the requirements of Appendix B. QEC items shall receive a visual inspection.

2.2.1 **Disassembly.** Disassemble engine as required by Appendix A.

2.2.2 **Inspection.** MEBG inspection requirements are listed in Appendix A. As a minimum, all exposed parts shall receive a visual inspection. Refer to Appendix C for a complete listing of Service Bulletin requirements.

2.3 **Accessories.** Check and inspect engine accessories in accordance with requirements given in Appendix B.

2.4 **Quick Engine Change (QEC).** At each scheduled or unscheduled shop visit, overhaul / exchange through the manufacturer, the following QEC items:

NOMENCLATURE	PART NUMBER	QUANTITY
Forward Cone Bolt	R18210-2	2 each
Aft Cone Bolt	R18211-2	1 each

Note: The cone bolts shall be placed in a protective container and attached to the engine stand for shipment. Provide appropriate overhaul documentation.

All remaining QEC items shall as a minimum receive a visual inspection.

3.0 UNSCHEDULED REPAIRS

3.1 **Field Team.** Upon notification by the ACO, the Contractor shall provide Field Team support to perform depot level repairs. The Contractor shall coordinate with the using activity for engine preparation prior to Field Team arrival. The Contractor shall provide details of repairs accomplished and/or inspection results to the applicable C-9 Program Manager.

3.2 **Shop Visits.** Upon notification by the ACO, the Contractor shall induct engines for unscheduled repairs. The Contractor shall perform engine inspections and tests as necessary to verify reason for removal. Following initial evaluation, provide applicable C-9 Program Office with scope of work, recommendations (also provide options), and estimated costs to repair based on options. Accomplish repairs as directed by the ACO. ESV-1 or ESV-2 may be accomplished in conjunction with repair.

	ENGINE TEST					
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-00-00	Engine Testing		1	The engine shall be tested to a Type III overhaul		X
				acceptance and performance test in accordance		
				with PWA JT8D engine manual (P/N 481672).		
				Chapter 72-00-00.		
			2	Use MIL-L-23699 Oil or P & W approved oils	X	X
			3	Engine must pass a three-ratio stall margin check.	X	X
			4	Vibration to be to overhaul limits.		X
			5	Perform serviceability test for fuel de-icing and anti-icing	X	X
				Whitaker valves.		
			6	Record #4 and #5 bearing scavenge oil tube temperatures	X	X
				during all engine tests (record actual temperature		
				using diagnostic tabs or thermocouple).		
			7	Borescope engine after post-maintenance tests.	X	X
			8	Preserve engine per engine maintenance manual	X	X
				(P/N 481671). Marketing to contact customer to		
				determine type of preservation 10 days prior to		
				shipment.		
			9	Borescope prior to and after pre-induction test.	X	
			10	Pre-induction test to be Type III Heavy Maintenance Limits.	X	
			11	Post induction test to be Type III Heavy Maintenance Limits.	X	
			12	Obtain oil sample from N2 gearbox on pre-induction test.	X	
				if recent JOAP data is not with engine records.		
				Oil sample not required at post maintenance tests.		

	COMMON PARTS					
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-09-00	Common Parts General		1	Accomplish receiving inspection of engine, noting general	X	X
				condition of external hardware.		
			2	Document shortages.	X	X
			3	Refer to detail parts section for individual parts.	X	X
				NDT as required below.		
72-09-70	Parts External		1	Clean.	X	X
			2	Visually and dimensionally inspect.	X	X
72-09-71	Tubing, External		1	Clean.	X	X
			2	Visually inspect	X	X
72-09-73	Brackets, External		1	Clean.	X	X
			2	Visually inspect.	X	X

FRONT ACCESSORY DRIVE GROUP						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-21-00	Front Accessory Drive		1	Disassemble completely.		X
	Group		2	Clean as specified by engine manual.		X
			3	Strip and recoat.		X
			4	Accomplish Service Bulletins listed in appendix.	X	X
			5	Reassemble.		X
			6	Visual inspect.	X	X
72-21-01	Support, Front Accessory		1	F.P.I.		X
			2	Visually and dimensionally inspect. Repair as required.		X
72-21-02	Pump, No. 1 Bearing		1	F.P.I. and M.P.I.		X
	Scavenge		2	Visually and dimensionally inspect.		X
72-21-03	Gearshaft, Tachometer		1	M.P.I.		X
	(N1) Drive Spacer		2	Visually and dimensionally inspect.		X
72-21-05	Seal Housing and Seal,		1	Replace tach seal.	X	X
	N1 Tachometer Drive Oil					

FRONT COMPRESSOR GROUP						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-23-00	Fan Inlet Group		1	Disassemble completely to remove #1 bearing, Fan Inlet		X
				Case, C-1 Disk Assy, Front Fan Case, C-1 Stator,		
				Rear Fan Case, and C-2 Disk Assy. Remove No. 1		
				Bearing from Fan Inlet Case.		
			2	Disassemble to remove No.1 Bearing, Fan Inlet Case, C-1	X	
				Disk Assy.		
			3	Disassemble to remove Front Fan Case, C-1 Stator and Rear	X	
				Fan case as one Unit.		
			4	Remove C-2 Disk Assy.	X	
			5	Clean all parts as specified by engine manual.	X	X
			6	Visually and dimensionally inspect as specified by engine		X
				manual.		
			7	Comply with Service Bulletins listed in attached Appendix.	X	X
			8	Re-assemble per engine manual.		X
72-23-01	Fan Inlet Case		1	Visually inspect.	X	X
			2	Air and oil pressure check.	X	X
			3	F.P.I. and dimensionally inspect.		X
72-23-02	No. 1 Bearing Housing		1	F.P.I. as required.		X
			2	Visually and dimensionally inspect.		X
			3	Visually inspect.	X	
72-23-03	Support, Rear No. 1		1	F.P.I. as required.		X
	Bearing		2	Visually and dimensionally inspect.		X
72-23-04	Tube, Connector		1	F.P.I. as required.		X
			2	Visually and dimensionally inspect.		X

FRONT COMPRESSOR GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-23-06	Duct, Compressor Inlet		1	F.P.I. as required.		X
			2	Visually and dimensionally inspect.		X
			3	Visually inspect.	X	
72-23-15	Plate, Bearing Retaining		1	F.P.I. as required.		X
			2	Visually and dimensionally inspect.		X
			3	Visually inspect.	X	
72-23-18	Nut, No. 1 Bearing Outer		1	M.P.I.		X
	Race Retaining		2	Visually and dimensionally inspect.		X
			3	Plate per SPOP 23.		X
72-23-81	Nut No. 1 Bearing Inner		1	M.P.I.		X
			2	Visually and dimensionally inspect.		X
			3	Plate per SPOP 23.		X
72-23-83	Seal No. 1 Bearing		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X
72-33-00	Front Compressor Group		1	Disassemble completely.		X
	Disassemble		2	Review life remaining on all time/cycle controlled parts.		X
			3	Clean all parts as specified by engine manual.		X
			4	As required, check fits and clearances specified.	X	X
			5	Comply with Service Bulletins listed in attached Appendix.		X
			6	Re-assemble module.	X	X
			7	Balance to 1/2 PWA limits.		X

	FRONT COMPRESSOR GROUP (cont.)					
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-33-02	Disk & Blade Assembly,		1	De-blade disk completely.	X	X
	Stage 1		2	Re-assemble disk and blades per engine manual	X	X
				requirements.		
			3	Check balance assembly to 1/2 PWA limits.	X	X
72-33-04	Disk & Blade Assy Stage 2		1	De blade disk completely.	X	X
			2	Reassemble Disk and Blades per eng manual requirements	X	X
			3	Check Balance Assy to ½ PWA limits.	X	X
72-33-05	Disk & Blade Assembly,		1	De-blade disk completely.		X
	Stage 3		2	Re-assemble disk and blades per engine manual		X
				requirements.		
			3	Check balance assembly to 1/2 PWA limits.		X
72-33-06	Disk & Blade Assembly,		1	De-blade disk completely.		X
	Stage 4		2	Re-assemble disk and blades per engine manual		X
				requirements.		
			3	Check balance assembly to 1/2 PWA limits.		X
72-33-07	Disk & Blade Assembly,		1	De-blade disk completely.		X
	Stage 5		2	Re-assemble disk and blades per engine manual		X
				requirements.		
			3	Check balance assembly to 1/2 PWA limits.		X
72-33-08	Disk & Blade Assembly,		1	De-blade disk completely.		X
	Stage 6		2	Re-assemble disk and blades per engine manual		X
				requirements.		
			3	Check balance assembly to 1/2 PWA limits.		X

FRONT COMPRESSOR GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-33-12	Tierods, Front		1	Clean per engine manual.		X
			2	M.P.I. inspect.		X
			3	Visually and dimensionally inspect.		X
			4	Measure length.		X
			5	Ni-cad plate per SPOP 25.		X
			6	Apply anti-galling compound per SPOP 156.		X
72-33-13	Tierods, Rear		1	Clean per engine manual.		X
			2	M.P.I. inspect.		X
			3	Visually and dimensionally inspect.		X
			4	Measure length.		X
			5	Ni-cad plate per SPOP 25.		X
			6	Apply anti-galling compound PWA 550 Per SPOP 156.		X
72-33-14	Nut, Front and Rear		1	Clean per engine manual.		X
	Tierods		2	Visually inspect.		X
			3	M.P.I.		X
			4	Ni-cad plate per SPOP 25.		X
72-33-15	Plate, 1st Stage Blade		1	Clean per engine manual.	X	X
	Retaining		2	Visually and dimensionally inspect for cracks and	X	X
				surface damage.		
			3	S/B 5841 required.	X	X
72-33-16	Air seal, 2nd Stage		1	Clean per engine manual.	X	X
			2	Visually and dimensionally inspect for knife edge wear,	X	X
				concentricity and flatness.		
			3	F.P.I.		X
72-33-17	Front Comp. Hub Plug		1	Visually inspect.	X	X

FRONT COMPRESSOR GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-33-21	Blade, 1st Stage		1	F.P.I.	X	X
			2	Eddy current inspect (S/B 5758)	X	X
			3	Visually and dimensionally inspect. Overhaul/inspect.	X	X
			4	Accomplish specialty repairs:	X	X
				a) Hard coat PWA 46 or 256-4 to mid span shroud.		
				b) EB weld repair.		
			5	Restore surface finish and profile by vibratory burnish.	X	X
			6	Glass beed peen airfoil.	X	X
			7	Shot peen blade root per SPOP 501.	X	X
			8	Apply anti-galling compound per SPOP 160.	X	X
			9	Moment weigh blades.	X	X
72-33-23	Blade, 2nd stage		1	Clean per engine manual.	X	X
			2	F.P.I.	X	X
			3	Ultrasonic inspect blade lugs (S/B 5729).	X	X
			4	Visually and dimensionally inspect. Overhaul/inspect.	X	X
			5	Vibratory burnish process to restore surface finish per	X	X
				SPOP 184.		
			6	Glass beed peen airfoil.	X	X
			7	Shot peen root per SPOP 501	X	X
			8	Apply anti-galling compound to blade root per SPOP 160.	X	X
			9	Moment weigh blades and classify.	X	X

FRONT COMPRESSOR GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-33-24	Blade, Stage 3		1	Clean per engine manual.		X
			2	F.P.I.		X
			3	Visually and dimensionally inspect.		X
			4	Vibratory burnish process per SPOP 184.		X
			5	Glass been peen airfoil.		X
			6	Shot peen blade root per SPOP 501.		X
			7	Apply anti-galling compound per SPOP 160.		X
			8	Weigh blades.		X
			9	Visual inspect insitu.		X
72-33-25	Blade, Stage 4		1	Clean per engine manual.		X
			2	F.P.I.		X
			3	Visually and dimensionally inspect.		X
			4	Vibratory burnish process per SPOP 184.		X
			5	Glass beed peen airfoil.		X
			6	Shot peen blade root per SPOP 501.		X
			7	Apply anti-galling compound per SPOP 160.		X
72-33-26	Blade, Stage 5		1	Clean per engine manual.		X
			2	F.P.I.		X
			3	Visually and dimensionally inspect.		X
			4	Vibratory burnish process per SPOP 184.		X
			5	Glass beed peen airfoil.		X
			6	Shot peen blade root per SPOP 501.		X
			7	Apply anti-galling compound per SPOP 160.		X
			8	Weigh blades.		X

FRONT COMPRESSOR GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-33-27	Blade, Stage 6		1	Clean per engine manual.		X
			2	F.P.I.		X
			3	Visually and dimensionally inspect.		X
			4	Vibratory burnish process per SPOP 184.		X
			5	Glass beed peen airfoil.		X
			6	Shot peen blade root per SPOP 501.		X
			7	Apply anti-galling compound per SPOP 160.		X
			8	Weigh blades.		X
			9	If exposed , visually inspect insitu, otherwise borescope.	X	
72-33-28	Pins, 2nd Stage		1	Clean using vibratory mill.	X	X
			2	Visually and dimensionally inspect.	X	X
			3	Pinhole taper wear max .0025".	X	X
72-33-31	Hub, 1st Stage Front		1	Visually and dimensionally inspect per engine manual.	X	X
				Overhaul/inspect.		
			2	F.P.I. inspect "Ultra High Sensitivity".	X	X
			3	Eddy current inspect rim slot and hub web.	X	X
			4	Shot peen blade slots and web radius per SPOP 501.	X	X
			5	Apply anti-galling compound per SPOP 160.	X	X
			6	Comply with ASB 6104 as applicable.	X	X
72-33-33	Disk, 2nd Stage		1	F.P.I.	X	X
			2	Visually and dimensionally inspect. Overhaul/inspect.	X	X
			3	Shot peen disk tierod holes and rim per SPOP 501. Disk	X	X
				P/N 740502 does not require tie-rod hole peening.		
			4	Apply anti-galling compound per SPOP 160.	X	X

FRONT COMPRESSOR GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-33-34	Disk, 3rd Stage		1	F.P.I. (M.P.I. steel disk).		X
			2	Visually and dimensionally inspect.		X
			3	Shot peen per SPOP 501 and Ni-cad plate steel disk (P/N 494903 or 745803) per SPOP 25.		X
			4	Apply anti-galling compound to disk blade slot per		X
				SPOP 160.		
72-33-35	Hub, 4th Stage		1	F.P.I. or M.P.I. (steel hub).		X
			2	Visually and dimensionally inspect.		X
			3	Corrosion protect Steel Hubs only with Ni-Cad Plating.		X
			4	Shot peen blade slots per SPOP 501 steel hub.		X
			5	Apply anti-galling compound to splines and blade slots		X
				per SPOP 160 (steel hub).		
			6	Comply with ASB 4151.		X
72-33-36	Disk, 5th Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X
			3	Shot peen blade slots as required per SPOP 501.		X
			4	Apply anti-galling compound per SPOP 160.		X
72-33-37	Disk, 6th Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect. Overhaul inspect.		X
			3	Shot peen blade slots as required per SPOP 501.		X
			4	Apply anti-galling compound per SPOP 160.		X
			5	Check bore concentricity with snap diameter.		X
72-33-41	Spacer, 1st to 2nd		1	F.P.I.	X	X
			2	Visually and dimensionally inspect per engine manual.	X	X
			3	Static balance.	X	X
72-33-42	Spacer, 2nd to 3rd		1	Not applicable to -9A model.		
72-33-43	Spacer, 3rd to 4th		1	F.P.I.		X
			2	Visually and dimensionally inspect per engine manual.		X
			3	Static balance.		X

FRONT COMPRESSOR GROUP (cont.)						
ENGINE SECTION	DESCRIPTION	CHANGE NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-33-44	Spacer 4th to 5th		1	F.P.I.		X
			2	Visually and dimensionally inspect per engine manual.		X
			3	Static balance.		X
72-33-45	Spacer, 5th to 6th		1	F.P.I.		X
			2	Visually and dimensionally inspect per engine manual.		X
			3	Static balance.		X
72-33-51	Stator Vane, Stage 1		1	Visually and dimensionally inspect.		X
			2	F.P.I. reworked vanes.		X
72-33-53	Stator, 2nd Stage		1	F.P.I. or M.P.I. (Steel Stator)		X
			2	Visually and dimensionally inspect. Overhaul inspect.		X
			3	Steel stator vibratory burnish.		X
			4	Restore coating as required per SPOP 148 (Steel		X
				Stator SPOP 309).		
72-33-54	Stator , 3rd Stage		1	F.P.I. or M.P.I. (Steel Stator)		X
			2	Visually and dimensionally inspect. Overhaul inspect.		X
			3	Steel stator vibratory burnish.		X
			4	Restore coating as required per SPOP 148 (Steel		X
				Stator SPOP 309).		
72-33-55	Stator, 4th Stage		1	F.P .I.		X
			2	Visually and dimensionally inspect. Overhaul inspect.		X
			3	Coat with PWA 110-21-9		X
			4	Check vane angle.		X

FRONT COMPRESSOR GROUP (cont.)						
ENGINE SECTION	DESCRIPTION	CHANGE NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-33-56	Stator, 5th Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect. Overhaul and inspect.		X
			3	Coat with PWA 110-21-9.		X
			4	Check vane angle.		X
72-33-66	Case Assembly,		1	Clean per engine manual.		X
	Front Fan		2	Visually and dimensionally inspect for blade rub, wear	X	X
				and cracking.		
72-33-67	Case Assembly,		1	Visually and dimensionally inspect for blade rub, wear,	X	X
	Rear Fan			and cracking.		
72-33-81	Coupling, Turbine Shaft		1	M.P.I. inspect.		X
			2	Visually inspect.		X
			3	Corrosion protect per PWA 110-2		X
72-33-82	Lock, Turbine Shaft		1	M.P.I.		X
	Coupling		2	Visually and dimensionally inspect.		X
			3	Ni-Cad plate.		X
72-33-83	Case, Fan Exit		1	Visually and dimensionally inspect, repair as required.		X
			2	As required, apply protective coating to case per		X
				SPOP 148.		
			3	Visually inspect.	X	

COMPRESSOR INTERMEDIATE GROUP						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-34-00	Compressor Intermediate		1	Disassemble completely.		X
	Group		2	Clean all parts as specified by engine manuals.		X
			3	Comply with Service Bulletins listed in appendix.		X
			4	Reassemble per engine manual.		X
72-34-01	Case, Compressor		1	Chemical clean to remove carbon, or positive air pressure		X
	Intermediate			pyrolytic method clean to remove carbon.		
			2	Power Wash.		X
			3	X-Ray inspect.		X
			4	F.P.I.		X
			5	Visually and dimensionally inspect per engine manual.		X
			6	Pressure check Intermediate Case		
			7	To improve on overall engine vibration, accomplish		X
				engine build/stack up dimensions for run out and		
				concentricity. The No. 2 and No. 3 bearing bore		
				is to be concentric within .004" FIR and lips parallel		
				within .002" FIR, when mounted on fixture which shall		
				be restrained flat and concentric.		
72-34-07	Duct, Front Compressor		1	F.P.I.		X
	Fan Outer		2	Visually and dimensionally inspect.		X
			3	To prevent 6th bleed port distortion repair bleed port inner		X
				diameter by epoxy PWA 609 or 3M 2054.		
			4	Apply protective varnish per SPOP 152 as required.		X
			5	Visually inspect.	X	

COMPRESSOR INTERMEDIATE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-34-08	Duct, Fan Discharge		1	F.P.I.		X
	Rear Compressor Outer		2	Visually and dimensionally inspect.		X
			3	The rear flange shall be parallel to the front within .010"		X
				the rear flange snap inner diameter shall be		
				concentric to the front outer diameter within .010".		
			4	Apply protective coating per SPOP 152.		X
			5	Visually inspect.	X	
72-34-09	Nozzle, No. 2 & 3 Bearing		1	Visual inspect.		X
	Oil Pressure		2	F.P.I.		X
			3	Flow check.		X
72-34-10	Housing , Gearbox		1	Visually and dimensionally inspect.		X
	Drive Bearing					
72-34-13	Rings, No. 2 Bearing		1	Visually and dimensionally inspect.		X
	Seal Rings					
72-34-30	Housing Assembly,		1	F.P.I.		X
	No. 3 Bearing		2	Visually and dimensionally inspect.		X
			3	Assemble.		X
72-34-31	Gearbox, Drive Bevel		1	M.P.I.		X
	Gear		2	Visually and dimensionally inspect.		X
72-34-33	Bearing, No. 3		1	M.P.I.		X
			2	Visually and dimensionally inspect.		X

COMPRESSOR INTERMEDIATE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-34-34	Nut, No.3 Bearing		1	Visually and dimensionally inspect.		X
	Retaining		2	Replace silver plate per SPOP 28.		X
72-34-36	Spacer, No. 3 Bearing Labyrinth Seal		1	Visually a& Dimensionally Inspect		X
72-34-37	Nut, No. 3 Bearing Inner		1	M.P.I.		X
	Race Retaining		2	Visually and dimensionally inspect.		X
			3	Restore silver plate per SPOP 23.		X
72-34-40	Seal, No. 3 Bearing		1	Visually and dimensionally inspect.		X
	Labyrinth					
72-34-43	Manifold, Front		1	F.P.I.		X
	Air bleed		2	Visually and dimensionally inspect.		X
			3	Visually inspect.	X	
72-34-44	Sleeves, Front Bleed		1	Visually and dimensionally inspect.		X
	Manifold		2	Visually inspect.	X	
72-34-45	Liner, Front Bleed		1	Visually inspect.	X	X
	Expansion					
72-34-46	Tubes, Rear Compressor		1	Visually inspect.	X	X
	Low Pressure Air					
	Transfer					

COMPRESSOR INTERMEDIATE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-34-50	Gearshaft Assembly,		1	M.P.I.		X
	Gearbox Drive Bevel		2	Visually and dimensionally inspect.		X
			3	Assemble.		X
72-34-51	Gearbox, Gearbox Drive		1	M.P.I.		X
	Bevel		2	Visually and dimensionally inspect.		X
	(Front)		2	Visually and dimensionally inspect.		X
72-34-52	Coupling, Gearbox Drive		1	M.P.I.		X
			2	Visually & Dimensionally Inspect.		X
72-34-80	Drive Shaft, (Tower Shaft) Gearbox		1	M.P.I.		X
			2	Visually & Dimensionally Inspect.		X
72-34-81	Seal, #2 bearing Air (Front)		1	F.P.I		X
			2	Visually & Dimensionally Inspect.		X
72-34-82	Seal, #2 Bearing Air		1	F.P.I.		X
	(Rear)		2	Visually and dimensionally inspect.		X
72-34-83	No. 2 Bearing		1	M.P.I.		X
			2	Visually and Dimensionally inspect.		X
72-34-84	Nut, No.2 Bearing		1	M.P.I.		X
	Inner Race Retaining		2	Visually and dimensionally inspect.		X
			3	Plate per SPOP 23.		X
72-34-85	Nut, No. 2 Bearing Outer Race Retaining		1	M.P.I.		X
			2	Visually and dimensionally inspect.		X
			3	Plate per SPOP 23.		X
72-34-86	Baffle, No. 2 Bearing		1	Visually and dimensionally inspect.		X
	Front Oil					
72-34-87	Baffle, No. 2 Bearing		1	Visually and dimensionally inspect.		X

N2 COMPRESSOR MODULE						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-00	Compressor Module		1	Disassemble compressor module completely	XN	X
			2	Clean all parts as required per engine manual	XN	X
			3	Review life remaining parts	XN	X
			4	Comply with S/B listed in appendix	XN	X
			5	Balance to 1/2 PWA limits	XN	X
			6	Dimensional inspect, fits and clearances.	XN	X
			7	Reassemble.	XN	X
72-36-02	Disk & Blade (C7)		1	De-blade disk completely	XN	X
	Assembly		2	Re-assemble disk & blades	XN	X
			3	Balance to 1/2 PWA limits.	XN	X
			4	Borescope inspect.	X	
72-36-03	Disk & Blade (C8)		1	De-blade disk completely	XN	X
	Assembly		2	Re-assemble disk & blades	XN	X
			3	Balance to 1/2 PWA limits.	XN	X
72-36-04	Disk & Blade (C9)		1	De-blade disk completely	XN	X
	Assembly		2	Re-assemble disk & blades	XN	X
			3	Balance to 1/2 PWA limits.	XN	X
72-36-05	Disk & Blade (C10)		1	De-blade disk completely	XN	X
	Assembly		2	Re-assemble disk & blades	XN	X
			3	Balance to 1/2 PWA limits.	XN	X
72-36-06	Disk & Blade (C11)		1	De-blade disk completely	XN	X
	Assembly		2	Re-assemble disk & blades	XN	X
			3	Balance to 1/2 PWA limits.	XN	X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-07	Disk & Blade (C12)		1	De-blade disk completely	XN	X
	Assembly		2	Re-assemble disk & blades	XN	X
			3	Balance to 1/2 PWA limits.	XN	X
72-36-08	Disk & Blade (C13)		1	De-blade disk completely	X	X
	Assembly		2	Re-assemble disk & blades	X	X
			3	Balance to 1/2 PWA limits.	X	X
			4	Visually inspect.	X	
72-36-11	Compressor Spacers		1	Visually and dimensionally inspect.	XN	X
	Stages		2	M.P.I.	XN	X
72-36-16	7-8		3	Accomplish out -of-round limit & concentricity	XN	X
	8-9			inspection requirements for snap diameter		
	9-10			(.015" 00R & .001" concentric)		
	10-11		4	Coat with NiCad per engine manual	XN	X
	11-12		5	Comply with ASB 5649 integral sleeve spacers	XN	X
	12-13		6	Balance	XN	X
72-36-17	Front Hub (Separable)		1	M.P.I.	XN	X
			2	Visually & dimensionally inspect per engine manual	XN	X
				repair as required		
			3	Ni-cad plate per SPOP 25	XN	X
			4	Balance.	XN	X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-18	Rear Hub		1	F.P.I. and eddy current inspect splines (SB 5975)	XN	X
			2	Visually and dimensionally inspect per engine manual	XN	X
			3	To assure uniform assembly stack-up which contributes	XN	X
				to improved engine vibration, maintain disk/hub fit of		
				0025" - .0045".		
			4	Balance	XN	X
72-36-19	Rear Compressor		1	Visual and dimensionally inspect, repair as required.	XN	X
	Rotor Tube		2	Tubes with rear tip machined off may continue in	XN	X
				service in this configuration.		
72-36-20	Tie-rods		1	FPI per SPOP 82	XN	X
			2	Visually and dimensionally inspect for thread	XN	X
				condition, corrosion, pitting and stretch		
			3	Shot peen per SPOP 501	XN	X
			4	Apply anti-galling compound per SPOP 146	XN	X
72-36-21	Tie-rod nuts		1	M.P.I. per SPOP 82.	XN	X
			2	Strip and re-plate silver plating per SPOP 24.	XN	X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-22	Stage 7 air seal		1	M.P.I.	XN	X
			2	Visually and dimensionally inspect, repair as necessary	XN	X
			3	Coat with NiCad per engine manual	XN	X
72-36-31	Stage 7 blades		1	F.P.I.	XN	X
			2	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			3	Maintain Category "A" requirements for blade chord	XN	X
				width.		
			4	Vibratory burnish blades to improve surface finish	XN	X
				per SPOP 184.		
			5	Shot peen blade root per SPOP 501.	XN	X
			6	Apply PWA 474 anti-galling compound to roots per SPOP 160.	XN	X
72-36-32	Stage 8 blade		1	F.P.I.	XN	X
			2	Eddy current inspect	XN	X
			3	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			4	Maintain Category "A" requirements for blade chord width.	XN	X
			5	Vibratory burnish blades to improve surface finish	XN	X
				per SPOP 184.		
			6	Shot peen blade root per SPOP 501.	XN	X
			7	Apply PWA 474 anti-galling compound to roots per SPOP 160.	XN	X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-33	Stage 9 blades		1	F.P.I.	XN	X
			2	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			3	Maintain Category "A" requirements for blade chord width.	XN	X
			4	Vibratory burnish blades to improve surface finish	XN	X
				per SPOP 184.		
			5	Shot peen blade root per SPOP 501.	XN	X
			6	Apply PWA 474 anti-galling compound to roots per SPOP 160.	XN	X
72-36-34	Stage 10 blades		1	M.P.I	XN	X
			2	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			3	Maintain Category "A" requirements for blade chord width.	XN	X
			4	Vibratory burnish blades to improve surface finish	XN	X
				per SPOP 184.		
			5	Shot peen blade root per SPOP 501.	XN	X
			6	Apply PWA 474 anti-galling compound to roots per SPOP 160.	XN	X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-35	Stage 11 Blades		1	M.P.I.	XN	X
			2	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			3	Maintain Category "A" requirements for blade chord width.	XN	X
			4	Vibratory burnish blades to improve surface finish	XN	X
				per SPOP 184.		
			5	Shot peen blade root per SPOP 501.	XN	X
			6	Apply PWA 474 anti-galling compound to roots per SPOP 160.	XN	X
72-36-36	Stage 12 Blades		1	M.P.I.	XN	X
			2	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			3	Maintain Category "A" requirements for blade chord width.	XN	X
			4	Vibratory burnish blades to improve surface finish	XN	X
				per SPOP 184.		
			5	Shot peen blade root per SPOP 501.	XN	X
			6	Apply PWA 474 anti-galling compound to roots per SPOP 160.	XN	X
72-36-37	Stage 13 Blades		1	M.P.I		X
			2	Visually and dimensionally inspect per engine manual,		X
				overhaul.		
			3	Maintain Category "A" requirements for blade chord width.		X
			4	Vibratory burnish blades to improve surface finish		X
				per SPOP 184.		
			5	Shot peen blade root per SPOP 501.		X
			6	Apply PWA 474 anti-galling compound to roots per SPOP 160.		X
72-36-38	Pins, 7th Stage Blades		1	Visually and dimensionally inspect per engine manual.	XN	X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-41	Stage 7 disk		1	Strip surface treatments and plated repairs	XN	X
			2	M.P.I.	XN	X
			3	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			4	Perform butterfly polish of tie-rod holes as required	XN	X
				(Per SPOP 502).		
			5	Corrosion protect with Nicad	XN	X
			6	Apply anti-gallant compound per SPOP 160.	XN	X
			7	Comply with Alert Service Bulletin 4024	XN	X
			8	Balance	XN	X
72-36-42	Stage 8 disk/hub		1	Strip surface treatments.	XN	X
			2	M.P.I.	XN	X
			3	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			4	Comply with Alert Service Bulletin 4723 and 5154	XN	X
			5	Shot peen disk blade slots per SPOP 501	XN	X
			6	Corrosion protect with Nicad	XN	X
			7	Apply anti-galling compound per SPOP 160	XN	X
			8	Balance.	XN	X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-43	Stage 9 disk		1	Strip surface treatments.	XN	X
			2	M.P.I.	XN	X
			3	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			4	Perform butterfly polish of tie-rod holes as required per	XN	X
				SPOP 502 and shot peening per SPOP 501		
			5	Shot peen blade slots per SPOP 501	XN	X
			7	Corrosion protect with Nicad	XN	X
			6	Apply anti-galling compound to blade slots per SPOP 160	XN	X
			8	Comply with Alert Service Bulletin 4723, tie-rod holes crack	XN	X
				inspection.		
			9	Balance	XN	X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-44	Stage 10 disk		1	Strip surface treatments.	XN	X
			2	M.P.I.	XN	X
			3	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			4	Perform butterfly polish of tie-rod holes as required per	XN	X
				SPOP 502 and shot peening per SPOP 501		
			5	Shot peen blade slots per SPOP 501	XN	X
			6	Corrosion protect with Nicad	XN	X
			7	Apply anti-galling compound to blade slots per SPOP 160	XN	X
			8	Comply with Alert Service Bulletin 4723, tie-rod holes crack	XN	X
				inspection.		
			9	Balance	XN	X
72-36-45	Stage 11 disk		1	Strip surface treatments.	XN	X
			2	M.P.I.	XN	X
			3	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			4	Perform butterfly polish of tie-rod holes as required per	XN	X
				SPOP 502 and shot peening per SPOP 501		
			5	Shot peen blade slots per SPOP 501	XN	X
			6	Corrosion protect with Nicad	XN	X
			7	Apply anti-galling compound to blade slots per SPOP 160	XN	X
			8	Comply with Alert Service Bulletin 4723, tie-rod holes crack	XN	X
				inspection.		
			9	Balance	XN	X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-46	Stage 12 disk		1	Strip surface treatments.	XN	X
			2	M.P.I.	XN	X
			3	Visually and dimensionally inspect per engine manual,	XN	X
				overhaul.		
			4	Perform butterfly polish of tie-rod holes as required per	XN	X
				SPOP 502 and shot peening per SPOP 501		
			5	Shot peen blade slots per SPOP 501	XN	X
			6	Corrosion protect with Nicad	XN	X
			7	Apply anti-galling compound to blade slots per SPOP 160	XN	X
			8	Comply with Alert Service Bulletin 4723, tie-rod holes crack	XN	X
				inspection.		
			9	Balance	XN	X
72-36-47	Stage 13 disk		1	Strip surface treatments.		X
			2	F.P.I.		X
			3	Visually and dimensionally inspect per engine manual,		X
				overhaul.		
			4	Perform butterfly polish of tie-rod holes as required per		X
				SPOP 502 and shot peening per SPOP 501		
			5	Shot peen blade slots per SPOP 501		X
			6	Apply anti-galling compound to blade slots per SPOP 160		X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-51	7th Stage Vane and		1	Clean and strip stator vanes	XN	X
	Shroud		2	F.P.I. per SPOP 62	XN	X
			3	Visually and dimensionally inspect per engine manual for	XN	X
				FOD, erosion, braze joint condition and corrosion,		
				overhaul.		
			4	Accomplish vane angle checks to prevent off idle stalls	XN	X
				Ref. S/B 4420.		
			5	Replace damaged vane airfoils as required	XN	X
			6	Glass bead peen airfoils per SPOP 500	XN	X
			7	Coat with NiCad per engine manual	XN	X
			8	Maintain stator air seal clearance to overhaul limits.	XN	X
72-36-52	8th Stage Vane and		1	Clean and strip stator vanes	XN	X
	Shroud		2	F.P.I. per SPOP 62	XN	X
			3	Visually and dimensionally inspect per engine manual for	XN	X
				FOD, erosion, braze joint condition and corrosion,		
				overhaul.		
			4	Accomplish vane angle checks to prevent off idle stalls	XN	X
				Ref. S/B 4420.		
			5	Replace damaged vane airfoils as required	XN	X
			6	Glass bead peen airfoils per SPOP 500	XN	X
			7	Coat with Nicad per engine manual	XN	X
			8	Maintain stator air seal clearance to overhaul limits.	XN	X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-53	9th Stage Vane and		1	Clean and strip stator vanes	XN	X
	Shroud		2	F.P.I. per SPOP 62	XN	X
			3	Visually and dimensionally inspect per engine manual for	XN	X
				FOD, erosion, braze joint condition and corrosion,		
				overhaul.		
			4	Accomplish vane angle checks	XN	X
			5	Replace damaged vane airfoils as required	XN	X
			6	Glass bead peen airfoils per SPOP 500	XN	X
			7	Coat with NiCad per engine manual	XN	X
			8	Maintain stator air seal clearance to overhaul limits.	XN	X
72-36-54	10th Stage Vane		1	Clean and strip stator vanes	XN	X
	and Shroud		2	F.P.I. per SPOP 62	XN	X
			3	Visually and dimensionally inspect per engine manual for	XN	X
				FOD, erosion, braze joint condition and corrosion,		
				overhaul.		
			4	Accomplish vane angle checks	XN	X
			5	Replace damaged vane airfoils as required	XN	X
			6	Glass bead peen airfoils per SPOP 500	XN	X
			7	Coat with NiCad per engine manual	XN	X
			8	Maintain stator air seal clearance to overhaul limits.	XN	X

N2 COMPRESSOR MODULE (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-36-55	11th Stage Vane		1	Clean and strip stator vanes	XN	X
	and Shroud		2	F.P.I. per SPOP 62	XN	X
			3	Visually and dimensionally inspect per engine manual for	XN	X
				FOD, erosion, braze joint condition and corrosion,		
				overhaul.		
			4	Accomplish vane angle checks	XN	X
			5	Replace damaged vane airfoils as required	XN	X
			6	Glass bead peen airfoils per SPOP 500	XN	X
			7	Coat with Nicad per engine manual	XN	X
			8	Maintain stator air seal clearance to overhaul limits.	XN	X
72-36-56	12th Stage Vane		1	Clean and strip stator vanes	XN	X
	and Shroud		2	F.P.I. per SPOP 62	XN	X
			3	Visually and dimensionally inspect per engine manual for	XN	X
				FOD, erosion, braze joint condition and corrosion,		
				overhaul.		
			4	Accomplish vane angle checks	XN	X
			5	Replace damaged vane airfoils as required	XN	X
			6	Glass bead peen airfoils per SPOP 500	XN	X
			7	Coat with NiCad per engine manual	XN	X
			8	Maintain stator air seal clearance to overhaul limits.	XN	X
72-36-80	#4 Bearing Labyrinth		1	Clean and remove surface treatments.		X
	Seal		2	Visually and dimensionally inspect, checking outer		X
				diameter of knife edges, plating and anti-		
				galling conditions.		
			3	Apply anti-galling compound per SPOP 146.		X

	DIFFUSER GROUP					
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-37-00	Diffuser Assembly		1	Disassemble diffuser module completely.		X
			2	Clean all parts as specified by engine manual, overhaul.		X
			3	Pressure check oil tube bushings.		X
			4	Reassemble.		X
72-37-01	Case, Diffuser		1	F.P.I.		X
			2	Pressure test turbine cooling air pressure sense tube.		X
			3	Pressure test oil tube bushings.		X
			4	Visually and dimensionally inspect, repair as required by		X
				engine manual.		
			5	The #4 bearing housing support flange face shall be		X
				square with snap within .001" FIR and parallel to		
				front and rear flanges within .002" FIR.		
			6	Surface treat per PWA 110-2 or 110-3.		X
			7	Visually inspect insitu.	X	
72-37-02	Stator Assembly,		1	Clean and strip stator assembly.		X
	Compressor Exit		2	F.P.I.		X
			3	Visually and dimensionally inspect.		X
			4	Accomplish vane angle checks.		X
			5	Glass bead peen airfoil per SPOP 500.		X
			6	Recoat with PWA 110-21-9		X
			7	Visually inspect insitu.	X	
72-37-05	Ring Seal, 13th Stage		1	Visually and dimensionally inspect.		X
			2	Check fit to 13th disk to control P.C.P.		X

DIFFUSER GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-37-07	Housing, #4 Bearing		1	F.P.I. and M.P.I.		X
			2	Pressure test.		X
			3	Visually and dimensionally inspect and repair as required.		X
72-37-08	Seal Assembly,		1	Pyrolytic clean to remove coking as required.		X
	#4 Bearing		2	Ultrasonic clean as required.		X
			3	Visually and dimensionally inspect.		X
			4	Reassemble and flow check.		X
72-37-10	Heat shield, #4 Bearing		1	Visually inspect.		X
72-37-11	Tubing, Diffuser Case		1	F.P.I.		X
			2	Visually and dimensionally inspect. Repair as necessary.		X
			3	Restore protective coating per SPOP 146.		X
72-37-13	Nozzle and Manifold		1	F.P.I.		X
	Assembly, No. 4 & 5		2	Flow check		X
	Bearing Oil					
72-37-14	Ring Assembly, No. 4		1	F.P.I.		X
	Bearing Oil Seal		2	Visually and dimensionally inspect.		X
72-37-15	Cleaner #4 Bearing Seal		1	F.P.I.		X
	Centrifugal Separator Air		2	Visually inspect.		X

DIFFUSER GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-37-81	Air Seal, #4 Bearing		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X
72-37-83	Bearing, No. 4		1	M.P.I.		X
			2	Visually and dimensionally inspect.		X
72-37-84	Nut, #4 Bearing inner Rear Retainer		1	M.P.I		X
			2	Visually & Dimensionally Inspect.		X
72-37-85	Nut, #4 Bearing Outer Rear retainer		1	M.P.I.		X
				Visually & Dimensionally Inspect.		X
72-37-86	Baffle Set, #4 Bearings		1	Visually inspect.		X
	Oil					
72-37-87	Nozzle, No. 4 Bearing		1	Visually inspect.		X
			2	Flow check.		X
72-37-88	Pump Assembly, #4 & 5		1	F.P.I. and M.P.I.	X	X
	Bearing Scavenge		2	Visually and dimensionally inspect. Overhaul	X	X
72-37-89	Drive Spur Gear,		1	M.P.I.	X	X
	#4 /5 Bearing Scavenge		2	Visually and dimensionally inspect. Overhaul.	X	X

DIFFUSER OUTER FAN						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-38-00	Diffuser Outer Fan Duct		1	Disassemble completely.		X
	Group		2	Clean as required by engine manual.		X
			3	Comply with Service Bulletin listed in appendix.		X
			4	Reassemble.		X
			5	Visually inspect insitu.	X	
72-38-01	Duct, Diffuser Outer Duct		1	F.P.I. (Special attention to forward flange 10:00 & 2:00		X
				position).		
			2	Visually and dimensionally inspect.		X
			3	F.P.I. insitu forward of 13th stage blade ports.	X	
72-38-83	Holders, Fuel Manifold		1	F.P.I.		X
	Packing		2	Visually and dimensionally inspect.		X
			3	Accomplish epoxy repair of sealing seat surfaces.		X
			4	Replace packing.		X
			5	Visually inspect insitu.	X	
72-38-84	Seat, Fuel Manifold		1	F.P.I.	X	X
	Sealing		2	Visually and dimensionally inspect.	X	X

COMBUSTION & NO. 5 BEARING SECTION						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-41-00	Combustion & No. 5		1	Disassemble completely.	X	X
	Bearing Section		2	Clean all parts as specified by engine manual.	X	X
			3	Comply with Service Bulletins listed in attached Appendix.	X	X
			4	Reassemble.	X	X
72-41-01	Heat shield, Turbine		1	M.P.I. and ultrasonic inspect (Ref. S/B 5900), bellows for	X	X
	Shaft Inner			cracks.		
			2	Leak test.	X	X
			3	Visually and dimensionally inspect as specified by engine	X	X
				manual. Check for corrosion on flange.		
			4	Check #5 bearing retaining plate for wear.	X	X
			5	Corrosion protect per AMS 2404 or PWA 595 aluminum	X	X
				coating.		
72-41-02	Heat shield Assembly,		1	Visually and dimensionally inspect.	X	X
	Turbine Shaft Outer					
72-41-03	Tube, No. 5 Bearing		1	F.P.I.	X	X
			2	Visually and dimensionally inspect.	X	X
72-41-04	Manifold Assembly,		1	F.P.I.	X	X
	No. 5 Bearing Oil		2	Visually and dimensionally inspect.	X	X
	Pressure		3	Flow test.	X	X
72-41-10	Inner Case,		1	F.P.I.	X	X
	Combustion Chamber		2	Visually and dimensionally inspect.	X	X
			3	Accomplish pressure test as required.	X	X

COMBUSTION & NO. 5 BEARING SECTION (cont.)						
ENGINE SECTION	DESCRIPTION	CHANGE NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-41-11	Outer Case,		1	Strip Case	X	X
	Combustion Chamber		2	M.P.I.	X	X
			3	Comply with ASB 5676, 5842, 6124, 6148 and SB 6202	X	X
				as applicable.		
			4	Visually and dimensionally inspect.	X	X
			5	Liquid pressure test as required.	X	X
			6	Recoat per PWA 595 or aluminum paint	X	X
				per SPOP 142 PWA 110-3. Sermatel.		
			7	Scrapped cases will be replaced with P/N 806748.		
72-41-13	Outer Case Nuts,		1	Visually inspect.	X	X
	Combustion Chamber		2	Recoat per SPOP 146.	X	X
72-41-14	Chambers, Combustion		1	Chambers configuration to be ASB 5639 - Category 1A.	X	X
			2	Hard coat bushings (Ref. S/B 4421).	X	X
72-41-15	Guides, Combustion		1	Visually inspect.	X	X
	Chambers		2	Accomplish reference check to guides.	X	X
				and PWA 1333 coatings.		
72-41-16	Pins, Combustion		1	Visually and dimensionally inspect.	X	X
	Chambers					
72-41-20	Housing Assembly		1	M.P.I.		X
	No. 5 Bearing		2	Visually and dimensionally inspect.	X	X
			3	Ensure housing does not exceed .010" FIR at module	X	X
				assembly. #5 hub run out to be maintained at .005"		
				FIR or less during run out check.		
			4	Corrosion coat with electroless nickel.	X	X
72-41-21	Damper, No. 5 Bearing		1	Visually and dimensionally inspect.		X

COMBUSTION & NO. 5 BEARING SECTION (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-41-22	Retaining Nut, No. 5		1	Clean.	X	X
	Bearing		2	Visually inspect.	X	X
72-41-24	Housing Assembly,		1	M.P.I.	X	X
	No. 5 Bearing		2	Visually and dimensionally inspect.	X	X
72-41-80	Nut, Turbine Gang		1	F.P.I.	X	X
	Angle Self Locking		2	Visually.	X	X
			3	Corrosion treat with electroless nickel.	X	X
72-41-81	Valve Assembly,		1	Replace.	X	X
	Fuel Drain					
72-41-82	Manifold, Combustion		1	Visually and dimensionally inspect.	X	X
	Chamber Drain					

TURBINE NOZZLE GROUP						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-51-00	Turbine Nozzle Group		1	Disassemble completely.	X	X
			2	Clean as per engine manual.	X	X
			3	Comply with Service Bulletins listed in the	X	X
				attached Appendix.		
			4	Reassemble.	X	X
			5	Fixture record A-5 nozzle area and inspect for seats and	X	X
				buttress gaps.		
72-51-01	Support Assembly,		1	F.P.I. Special attention to front flange radius for cracks.	X	X
	1st Stage Turbine Stator		2	Visually and dimensionally inspect.	X	X
72-51-02	Case, Turbine		1	F.P.I.	X	X
	Outer Front		2	Visually and dimensionally inspect.	X	X
72-51-03	Stator Seat		1	F.P.I.	X	X
			2	Visually and dimensionally inspect.	X	X
72-51-04	Vanes 1st Stage		1	Overhaul inspect.	X	X
			2	Install new or newly re-airfoiled vanes in specified "hot spot	X	X
				locations". Install Nag's with class of 13 -14 tenth		
				classes.		
			3	Classify vane areas per specified instructions.	X	X
72-51-05	Inner Rear Support,		1	F.P.I.	X	X
	Combustion Chamber		2	Visually and dimensionally inspect.	X	X
	(Outlet)		3	Apply diffused aluminum coating.	X	X

TURBINE NOZZLE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-51-06	Outer Rear Support,		1	F.P.I.	X	X
	Combustion Chamber		2	Visually and dimensionally inspect.	X	X
	(Outlet)		3	Apply diffused aluminum coating.	X	X
72-51-07	Nuts and Bolts,		1	Visually inspect.	X	X
	Turbine Nozzle		2	Apply SPOP 146 anti-galling compound.	X	X
72-51-08	Damper, 1st Stage		1	F.P.I.	X	X
	Turbine		2	Visually and dimensionally inspect.	X	X
72-51-09	Air seal, 1st Stage		1	F.P.I.	X	X
	Turbine		2	Visually and dimensionally inspect.	X	X
			3	Honeycomb type seal required.	X	X
72-51-15	Duct Assembly,		1	F.P.I.	X	X
	Combustion Chamber		2	Visually and dimensionally inspect.	X	X
	(Outlet)					
72-51-21	Rear Support,		1	F.P.I.	X	X
	Combustion Chamber		2	Visually and dimensionally inspect, overhaul.	X	X
			3	Comply with specified combustion chambers/support	X	X
				fit requirements.		
72-51-22	Outlet Duct ,Combustion		1	F.P.I.	X	X
	Chamber Inner		2	Visually and dimensionally inspect, overhaul.	X	X
			3	Recoat with Magnesium Zirconate (SB 5801).	X	X
72-51-23	Outlet Duct ,Combustion		1	F.P.I.	X	X
	Chamber Outer		2	Visually and dimensionally inspect, overhaul.	X	X
			3	Recoat with Magnesium Zirconate (SB 5801).	X	X

REAR COMPRESSOR DRIVE TURBINE GROUP						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-52-00	Rear Compressor		1	Disassemble completely. NOTE: Do not separate shaft		X
	Drive Turbine Group			from disk unless replacement or rework is required.		
			2	Clean all parts as specified by engine manual.	X	X
			3	Review life remaining parts for hours & cycles.	X	X
			4	Comply with Service Bulletins specified in the	X	X
				attached Appendix.		
			5	Reassemble.		X
			6	Balance to 1/2 PWA limits. Relocate blades as required.	X	X
72-52-01	Blades, 1st Stage		1	F.P.I., X-Ray and eddy current inspect as required		X
				per S/B 5021.		
			2	Accomplish permeability (Magneteoscope) inspection	X	X
				on post S/B 5021 T-1 blades (requirements for		
				sulfidation). Replace post S/B 5021 blades only with		
				P/N 840001.		
			3	Comply with service time marking requirements.		X
			4	Measure blade stretch.		X
			5	Check shroud twist.		X
			6	Perform blade lean check.		X
			7	Recoat blades with PWA 70/73.		X
			8	Visually inspect insitu.	X	
			9	Eddy current blades insitu if evidence of overtemp	X	
				(burn through). Send 1 blade for analysis. Overhaul		
				all remaining blades if not overtemp.		
72-52-02	Disk, 1st Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X
			3	Visually inspect insitu.	X	

REAR COMPRESSOR DRIVE TURBINE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-52-03	Shaft, Rear Compressor		1	F.P.I.		X
	Drive		2	Visually and dimensionally inspect.		X
			3	Check shaft for hardness.		X
72-52-04	Shaft (Integral Disk),		1	F.P.I.		X
	Rear Compressor		2	Visually and dimensionally inspect.		X
	Drive		3	Check service life remaining.		X
			4	Check for growth and hardness.		X
			5	Visually inspect insitu.	X	
72-52-05	Tierods, 1st Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X
			3	Apply anti-galling compound per SPOP 146.		X
72-52-06	Nuts, Disk Retaining		1	Visually inspect.		X
			2	Restore silver plate per SPOP 24.		X
72-52-07	Rivet/Bushings		1	Visually inspect.		X
72-52-08	Plates, Blade Retaining		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X
72-52-10	Air seal, #5 Bearing		1	F.P.I.	X	X
	Labyrinth		2	Visually and dimensionally inspect.	X	X

REAR COMPRESSOR DRIVE TURBINE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-52-11	Seal & Support		1	Chemical & Ultrasonic clean to remove carbon.	X	X
	Assembly, No. 5		2	M.P.I.	X	X
	Bearing		3	Visually and dimensionally inspect.	X	X
			4	To reduce oil leakage, per special instruction,	X	X
				apply sealant to mating surfaces and		
				pressure test at 80 PSI in 200° F H2O.		
			5	Corrosion protect per AMS 2404 or PWA 110-2	X	X
				to bellows.		
72-52-12	Seal, No. 5 Bearing		1	Visually and dimensionally inspect. Overhaul inspect.	X	X
	Carbon					
72-52-13	Heat shield, No. 5		1	Visually and dimensionally inspect.	X	X
	Bearing		2	Corrosion protect with PWA 110-3.	X	X
72-52-14	Spacer, No.5. Bearing		1	Visually and dimensionally inspect.	X	X
			2	Lab spacer faces.	X	X
72-52-15	Seal Seat, No. 5		1	Visually and dimensionally inspect.	X	X
	Bearing		2	Ensure oil holes are not restricted by	X	X
				accomplishing flow check.		
			3	Lap seal face.	X	X
72-52-16	No. 5 Bearing		1	Visually, dimensionally inspect and M.P.I. specified by	X	X
				engine manual. Overhaul inspect.		

REAR COMPRESSOR DRIVE TURBINE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-52-17	Retaining Nut, No.5		1	M.P.I.		X
	Bearing		2	Visually and dimensionally inspect.		X
			3	Ensure axial oil holes are not obstructed	X	X
				by checking with #43 Dia drill.		
			4	Silver plate inner diameter threads per		X
				SPOP 23.		
			5	Visually inspect.	X	
72-52-81	Coupling Nut, Rear		1	M.P.I.	X	X
	Compressor Drive		2	Visually and dimensionally inspect.	X	X
			3	Plate per SPOP 23.	X	X
72-52-82	Spacer, No. 4 1/2		1	M.P.I.		X
	Bearing Outer Race		2	Visually and dimensionally inspect.		X
			3	Visually inspect.	X	
72-52-83	Seal Liner, No. 4 1/2		1	Visually and dimensionally inspect.	X	X
	Bearing					
72-52-84	Retaining Nut, No. 4 1/2		1	M.P.I.	X	X
	Bearing Outer Race		2	Visually and dimensionally inspect.	X	X

FRONT COMPRESSOR DRIVE TURBINE GROUP						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-53-00	Front Compressor		1	Disassemble completely.		X
	Drive Turbine Group		2	Clean all parts as specified by engine manual.		X
			3	Review life remaining parts (Hours & Cycles).	X	X
			4	Reassemble per engine manual.	X	X
			5	Balance to 1/2 PWA limits.	X	X
			6	Comply with Service Bulletins per the attached Appendix.	X	X
72-53-02	Disk and Blade		1	De-blade		X
	Assembly, 2nd Stage		2	Reassemble per engine manual requirements.		X
			3	Balance.		X
			4	Visually inspect insitu.	X	
72-53-03	Disk and Blade		1	De-blade.		X
	Assembly, 3rd Stage		2	Reassemble per engine manual requirements.		X
			3	Balance.		X
			4	Borescope rivets PER S/B 4592.	X	
			5	Comply with S/B 5913.	X	
72-53-04	Disk and Blade		1	De-blade.		X
	Assembly, 4th Stage		2	Reassemble per engine manual requirements.		X
			3	Balance.		X
			4	Visually inspect insitu.	X	
72-53-11	Blades, 2nd Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect as required		X
				by engine manual.		
			3	Measure blade stretch, shroud rotation, blade		X
				twist, notch wear.		
			4	Shot peen blade root per SPOP 501.		X
			5	Recoat if required with PWA 73.		X

FRONT COMPRESSOR DRIVE TURBINE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-53-12	Blades, 3rd Stage		1	F.P.I.		X
			2	Visually and dimensional inspect as required		X
				by engine manual.		
			3	Measure blade stretch, shroud rotation, blade		X
				twist and notch wear.		
			4	Shot peen blade root per SPOP 501.		X
			5	Recoat if required by PWA 73.		X
			6	Comply with notch wear inspection per ASB 5913.		X
72-53-13	Blades, 4th Stage		1	F.P.I.		X
			2	Visually and dimensional inspect as required		X
				by engine manual.		
			3	Measure blade stretch, shroud rotation, blade		X
				twist and notch wear.		
			4	Shot peen blade root per SPOP 501.		X
			5	Recoat if required by PWA 73.		X
			6	Comply with notch wear inspection per ASB 5913.		X
72-53-15	Disk, 4th Stage		1	F.P.I.		X
	(Separable Disk/Hub)		2	Review service life remaining.		X
			3	Visually and dimensionally inspect as required		X
				by engine manual.		
			4	Measure disk grows, hardness.		X
			5	Balance.		X

FRONT COMPRESSOR DRIVE TURBINE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-53-16	Disk, 2nd Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect as required		X
				by engine manual.		
			3	Measure disk grows, hardness.		X
			4	Balance.		X
72-53-17	Disk, 3rd Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect as required		X
				by engine manual.		
			3	Measure disk grows, hardness.		X
			4	Balance.		X
72-53-18	Hub, 4th Stage		1	F.P.I.		X
	Integral Disk/Hub		2	Visually and dimensionally inspect as required		X
				by engine manual.		
			3	Measure disk grows, hardness.		X
			4	Balance.		X
72-53-19	Hub, 4th Stage		1	F.P.I. or M.P.I.		X
	Seperable		2	Visually and dimensionally inspect.		X
72-53-20	Shaft, Front Turbine		1	Clean No. 4 1/2 bearing oil holes per SPOP 203 & 208.		X
	Drive		2	M.P.I.		X
			3	Check shaft for tortional creep.		X
			4	Visually and dimensionally inspect as required		X
				by engine manual.		
			5	Eddy current inspect as required by engine	X	X
				manual.		
			6	Balance		X
			7	Check size and fit 4 1/2 Bearing to journal.	X	

FRONT COMPRESSOR DRIVE TURBINE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-53-21	Spacer Assembly,		1	F.P.I.		X
	Shaft to 3rd Stage		2	Visually and dimensionally inspect.		X
			3	Balance.		X
72-53-22	Spacer Assembly,		1	F.P.I.		X
	3rd to 4th Stage		2	Visually and dimensionally inspect.		X
			3	Balance.		X
72-53-27	Air seal, 3rd Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X
			3	Balance		X
72-53-28	Air seal, 4th Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X
			3	Balance.		X
72-53-30	Shield and Tube		1	F.P.I.		X
	Assembly, No. 4 1/2		2	Visually and dimensionally inspect.		X
	and 6 Bearing		3	Replace garlock seal.	X	X
			4	Flow and pressure check (as required based on visual	X	
				inspection).		
72-53-31	Tierods		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X
			3	Silver plate per SPOP 24.		X
72-53-32	Tierod Nuts, Front		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X

FRONT COMPRESSOR DRIVE TURBINE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-53-33	Tierod Nuts, Rear		1	F.P.I.		X
			2	Visually inspect.		X
			3	Silver plate per SPOP 24.		X
72-53-34	Retaining Nut, No. 4 1/2		1	M.P.I.	X	X
	Bearing Inner Race		2	Visually inspect.	X	X
			3	Plate threads per SPOP 23.	X	X
72-53-35	Face Seals,		1	Visually and dimensionally inspect. Overhaul.	X	X
	No 4 1/2 Bearing					
72-53-36	Seal Spacer,		1	Visually and dimensionally inspect. Overhaul.	X	X
	No. 4 1/2 Bearing Front		2	Check for flatness, lap as required.		X
72-53-37	Seal Spacer, No. 4 1/2		1	Visually and dimensionally inspect. Overhaul.	X	X
	Bearing Intermediate		2	Check for flatness, lap as required.		X
72-53-38	Seal Spacer, No. 4 1/2		1	Visually and dimensionally inspect. Overhaul.	X	X
	Bearing Rear		2	Check for flatness, lap as required.		X
72-53-39	Bearing, No. 4 1/2		1	Visually and dimensionally inspect as required by	X	X
				engine manual. Overhaul.		
			2	M.P.I.		X
72-53-40	Seals and Spacers,		1	Assemble as specified by engine manual.	X	X
	No. 6 Bearing					
72-53-42	Seal (Sleeve) Spacer		1	Visually and dimensionally inspect. Overhaul.	X	X
	No. 6 Bearing, Front		2	Check for flatness, lap as required.	X	X

FRONT COMPRESSOR DRIVE TURBINE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-53-43	Seal Spacer No. 6		1	Visually and dimensionally inspect. Overhaul.	X	X
	Bearing, Front		2	Check for flatness, lap as required.	X	X
72-53-44	Seal Spacer No. 6		1	Visually and dimensionally inspect. Overhaul.	X	X
	Bearing, Intermediate		2	Check for flatness, lap as required.	X	X
72-55-45	Seal Spacer No. 6		1	Visually and dimensionally inspect. Overhaul.	X	X
	Bearing, Rear		2	Check for flatness, lap as required.	X	X
72-53-46	Carbon Seals, No. 6		1	Remove and replace No. 6 carbon seals with new	X	X
	Bearing			P/N 805070 seals per SB 6164		
72-53-51	Case, Rear Turbine		1	F.P.I.		X
	Nozzle		2	Visually and dimensionally inspect.		X
			3	Visually inspect insitu.	X	
72-53-52	Spacer, Rotor Outer Seal		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X
72-53-53	Locks, 2nd and 3rd		1	F.P.I.		X
	Stator		2	Visually and dimensionally inspect.		X
			3	Classify locks by thickness.		X
72-53-54	Air seal Damper, 2nd		1	F.P.I.		X
	Stage Outer		2	Visually and dimensionally inspect.		X

FRONT COMPRESSOR DRIVE TURBINE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-53-56	Shroud and Ring		1	F.P.I.		X
	Assembly, 2nd Stage		2	Visually and dimensionally inspect.		X
	Vane		3	Maintain required vane foot to shroud flange		X
				fit of .001"L to .005"L.		
72-53-57	Shroud and Ring Assy, 3rd Stage vane			F.P.I.		
			1	Visually and dimensionally inspect.		X
			2	Maintain required vane foot to shroud flange		X
			3	fit of .001"L to .005"L.		X
72-53-58	Shroud and Ring		1	F.P.I.		X
	Assembly, 4th Stage		2	Visually and dimensionally inspect.		X
	Vane		3	Maintain required vane foot to shroud flange		X
				fit of .001"L to .005"L.		
72-53-59	Air seal Ring, 2nd Stage		1	F.P.I.		X
	Outer		2	Visually and dimensionally inspect.		X
			3	To prevent blade lock up, inspect for out of		X
				roundness of inner diameter honeycomb		
				when installed in case.		
72-53-60	Air seal Ring, 3rd Stage		1	F.P.I.		X
	Outer		2	Visually and dimensionally inspect.		X
			3	To prevent blade lock up, inspect for out of		X
				roundness of inner diameter honeycomb		
				when installed in case.		
72-53-61	Air seal Ring, 4th Stage		1	F.P.I.		X
	Outer		2	Visually and dimensionally inspect.		X
			3	To prevent blade lock up, inspect for out of		X
				roundness of inner diameter honeycomb		
				when installed in case.		

FRONT COMPRESSOR DRIVE TURBINE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-53-71	Vane, 2nd Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect as required		X
				by engine manual.		
			3	Maintain required vane foot to shroud flange		X
				clearance fit of .001"L to .005"L.		
			4	Classify 2nd vanes.		X
			5	Recoat as required.		X
72-53-72	Vane, 3rd Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect as required		X
				by engine manual.		
			3	Maintain required vane foot to shroud flange		X
				clearance fit of .001"L to .005"L.		
			4	Classify 3rd vanes.		X
			5	Recoat as required.		X
72-53-73	Vane, 4th Stage		1	F.P.I.		X
			2	Visually and dimensionally inspect as required		X
				by engine manual.		
			3	Maintain required vane foot to shroud flange		X
				clearance fit of .001"L to .005"L.		
			4	Classify 4th vanes.		X
			5	Recoat as required.		X
			6	Visually inspect insitu.	X	

EXHAUST CASE GROUP						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-54-00	Engine Exhaust		1	Visually inspect exhaust case for cracks and worn (.010”max) pins/bushings.	X	
	Case Section					
			2	Disassemble completely.		X
			3	Clean as specified by engine manual.	X	X
			4	Comply with Service Bulletins listed in attached Appendix.	X	X
			5	Reassemble.	X	X
			6	Comply with alignment check of #6 bearing and lip.	X	X
72-54-01	Exhaust Case		1	Soft grit blast entire case per SPOP 8.		X
			2	F.P.I.		X
			3	Visually and dimensionally inspect. Disassemble to the extent required to perform repairs.		X
			4	As required accomplish Pt7 boss weld crack repair		X
				(P/N 531439 pit boss).		
			5	Visually inspect insitu.	X	
72-54-02	Duct & Fairing,		1	F.P.I.		X
	Exhaust Case		2	Visually and dimensionally inspect.		X
			3	Visually inspect insitu.	X	
72-54-03	Struts (Support Rods),		1	M.P.I.		X
	No. 6 Bearing		2	Visually and dimensionally inspect.		X
			3	Inspect rods for stretch.		X
			4	Visually inspect insitu.	X	
72-54-04	Exhaust Case Boss,		1	M.P.I.		X
	No. 6 Bearing		2	Visually and dimensionally inspect.		X
72-54-05	Exhaust Case Boss		1	F.P.I.		X
	Bolt, No.6 Bearing		2	Visually inspect.		X

EXHAUST CASE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-54-07	Nut, #6 Bearing Strut		1	Visually inspect.		X
72-54-10	Pt7 Manifold and Tubing		1	F.P.I.		X
			2	Visually inspect and pressure check.		X
			3	Shot peen brazed fitting per SPOP 501.		X
			4	Visually inspect insitu and pressure check.	X	
72-54-11	Duct Segments, Fan		1	F.P.I.	X	X
	Exhaust Inner Rear		2	Visually inspect.	X	X
72-54-15	Oil Nozzle Assembly,		1	Visually inspect.	X	X
	No. 4 ½ Bearing		2	Flow check.	X	X
72-54-16	Retaining Plate,		1	F.P.I.	X	X
	No. 6 Bearing		2	Visually and dimensionally inspect.	X	X
72-54-17	Housing Assembly,		1	F.P.I.		X
	No. 6 Bearing		2	Visually and dimensionally inspect.		X
			3	Visually inspect insitu.	X	
			4	Dimensionally inspect seal bore and bearing bore.	X	X
72-54-20	No. 6 Bearing		1	M.P.I.	X	X
			2	Visually and dimensionally inspect as specified in	X	X
				engine manual. Overhaul.		
72-54-21	Internal Pressure Tube,		1	Visually inspect.	X	X
	No. 6 Bearing		2	Air pressure check.	X	X

EXHAUST CASE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-54-25	Scavenge Pump,		1	Disassemble.		X
	No. 6 Bearing Oil		2	F.P.I. and M.P.I, Inspect.		X
			3	Visually and dimensionally inspect.		X
			4	Visually inspect.	X	
			5	Flow check.	X	
72-54-26	Scavenge Pump		1	F.P.I.		X
	Housing, #6 Bearing Oil		2	Visually and dimensionally inspect.		X
72-54-30	Outer Duct, Fan Exhaust		1	F.P.I.		X
			2	Visually and dimensionally inspect. Check for cracks,	X	X
				mount bushing inner diameter.		
			3	Apply protective coating (steel duct only).		X
72-54-33	Strut, Fan Exhaust		1	F.P.I.		X
			2	Visually and dimensionally inspect.		X
			3	Apply anti-galling compound per SPOP 146.		X
			4	Visually inspect insitu. Check for looseness.	X	X
72-54-34	Strut Ball End, Fan		1	Visually inspect.		X
	Exhaust					
72-54-35	Strut Ball Socket and		1	Visually and dimensionally inspect.		X
	Seat, Fan Exhaust					
72-54-36	Strut Clevis (Support),		1	Visually and dimensionally inspect.		X
	Fan Exhaust					
72-54-37	Strut Bearing, Fan		1	Visually and dimensionally inspect.		X
	Exhaust					

EXHAUST CASE GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-54-80	Nut/ Bracket Gang,		1	F.P.I.	X	X
	Turbine (Rear)		2	Visually and dimensionally inspect.	X	X
72-54-81	Inner Duct Segments,		1	F.P.I.	X	X
	Fan Exhaust		2	Visually and dimensionally inspect.	X	X

MAIN ACCESSORY GEARBOX GROUP						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-61-00	Main Accessory		1	Disassemble completely.		X
	Gearbox Group		2	Clean all parts as per engine manual requirements.		X
			3	Accomplish Service Bulletins listed in attached Appendix.	X	X
			4	Reassemble.		X
			5	Pressure test.	X	X
			6	Visually inspect gearbox insitu.	X	
72-61-01	Rear Housing Assembly,		1	F.P.I.		X
	Gearbox		2	Visually and dimensionally inspect per engine manual		X
				requirements. Repair as required.		
			3	Paint as required; external surfaces only.		X
72-61-02	Front Housing Assembly,		1	F.P.I.		X
	Gearbox		2	Visually and dimensionally inspect.		X
			3	As required, install liner on CSD bore face.		X
			4	Paint as required; external surfaces only.		X
72-61-10	Drive Gearshaft		1	M.P.I.		X
	Assembly, Starter		2	Visually and dimensionally inspect.		X
72-61-11	Drive Spur Gearshaft,		1	M.P.I.		X
	Starter		2	Visually and dimensionally inspect.		X
72-61-12	Impeller, Rotary		1	M.P.I.		X
	Dearator (Front & Rear)		2	Visually and dimensionally inspect.		X
72-61-14	Gearshaft Coupling		1	M.P.I.		X
	Starter Drive		2	Visually and dimensionally inspect.		X

MAIN ACCESSORY GEARBOX GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-61-15	Bevel and Spur		1	M.P.I.		X
	Gearshaft, Gearbox Drive		2	Visually and dimensionally inspect.		X
	Gearbox Drive					
72-61-16	Bevel & Spur Gearshaft Assy		1	M.P.I.		X
			2	Visually & Dimensionally Inspect.		X
72-61-20	Accessory & Component		1	Assemble per engine manual requirements.		X
	Drive Gearshaft					
	Assembly (CSD)					
72-61-21	Accessory & Component		1	M.P.I.		X
	Drive Spur Gearshaft		2	Visually and dimensionally inspect.		X
	(CSD)		3	Inspect per SB 6152 when exposed	X	X
72-61-22	Accessory Drive Bevel		1	M.P.I.		X
	Gear (CSD)		2	Visually and dimensionally inspect.		X
72-61-23	Gearbox Coupling (CSD)		1	M.P.I.		X
			2	Visually and dimensionally inspect.		X
72-61-25	Fuel Pump Drive		1	Assemble per engine manual requirements.		X
	Gearshaft Assembly					
72-61-26	Fuel Pump Drive Spur		1	M.P.I.		X
	Gearshaft		2	Visually and dimensionally inspect.	X	X

MAIN ACCESSORY GEARBOX GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-61-27	Gearbox Drive, Spur		1	M.P.I.		X
	Gear		2	Visually and dimensionally inspect.		X
72-61-30	Gearshaft Assembly,		1	Disassemble/Assemble as per engine manual.		X
	Hydraulic Pump Drive					
	Gearbox Driveshaft		2	Visually and dimensionally inspect.		X
72-61-31	Bevel Drive Hyd Pump		1	M.P.I.		X
			2	Visually & Dimensionally Inspect.		X
72-61-36	Gearbox Coupling, Outer		1	M.P.I.		X
				Visually & Dimensionally Inspect.		X
72-61-37	Bevel Gear		1	M.P.I.		X
	Gearbox Driveshaft		2	Visually and dimensionally inspect.		X
72-61-40	(N2) Gearshaft Assembly,		1	Disassemble/Assemble per engine manual requirements.		X
	Tachometer Drive					
72-61-41	Tachometer Drive Bevel		1	M.P.I.		X
	Gearshaft		2	Visually and dimensionally inspect.		X
72-61-44	Tachometer Drive Oil		1	Disassemble/Assemble per engine manual requirements.		X
	Seal Housing & Seal					
72-61-50	Main Oil Pump Assembly		1	M.P.I. and F.P.I.		X
			2	Visually and dimensionally inspect.		X
			3	Assemble.		X
72-61-51	Oil Pressure Relief		1	Disassemble.		X
	Valve Assembly		2	Clean.		X
			3	Visually and dimensionally inspect.		X

MAIN ACCESSORY GEARBOX GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-61-54	Oil Filter Main (15) Micron		1	Replace with new 15-micron filter.	X	X
72-61-58	Cross Shafts Power		1	M.P.I.		X
	Lever		2	Visually and dimensionally inspect.		X
72-61-59	Accessory Drive Face		1	Replace all carbon Seal		X
	Type Oil Seals		2	Visually & Dimensionally Inspect.		X
				Visually & Dimensionally Inspect except for de-oiler.	X	
				Visually Inspect de-Oiler Seal With Mirror		
72-61-60	Linkage, Fuel Control		1	Visually inspect cross shaft/fuel control link for bearing	X	X
				condition.		
72-61-61	Coupling (Quick		1	Visually and dimensionally inspect.		X
	Disconnect) Fuel Pump					
	Front					
72-61-62	Coupling (Quick		1	Visually and dimensionally inspect.		X
	Disconnect) Fuel Pump					
	Rear					
72-61-63	Nut Gearbox Quick		1	Visually and dimensionally inspect.		X
	Disconnect					
72-61-65	Tank, Oil		1	Visually and dimensionally inspect. Overhaul.	X	X
			2	If contaminated, repair by cutting 2" X 2" square window	X	X
				in tank to gain access for cleaning.		
			3	X-Ray inspect if engine oil system metal contamination is evident.	X	X
			4	Navy Engines Only: Verify oil-servicing adapters installed.	X	X

MAIN ACCESSORY GEARBOX GROUP (cont.)						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-61-66	Oil Tank Cap		1	Visually inspect.		X
72-61-67	Strap Assembly Oil		1	Visually inspect.		X
	Tank					
72-61-80	Mounting Pins, Gearbox		1	Inspect main and front mounts for looseness. Pin to		X
				hangar .001" to .004" loose, Pin to gearbox .007"		
				.010" loose.		
			2	Visually and dimensionally inspect.		X
72-61-81	Mounting Bolts, Gearbox		1	M.P.I.		X
			2	Visually and dimensionally inspect.		X

FAN DISCHARGE SECTION						
ENGINE		CHANGE				
SECTION	DESCRIPTION	NO.	ITEM	INSTRUCTIONS	ESV #1	ESV #2
72-71-00	Fan Discharge Section		1	Clean parts as required by engine manual.		X
			2	Accomplish applicable bulletins listed in appendix.	X	X
72-71-01	Ducts, Fan Discharge		1	F.P.I. if required.		X
			2	Visually and dimensionally inspect.		X
72-71-02	Duct, Diffuser Inner Fan		1	Clean per engine manual.		X
			2	Visually inspect.		X
72-71-03	Duct, Combustion		1	Visually Inspect.	X	X
	Chamber and Turbine					
	Fan					
72-71-04	Liners, Combustion		1	Visually Inspect.	X	X
	Chamber and Turbine					
	Fan Duct Sound					
	Absorbing					
72-71-05	Inner Duct Segments,		1	Visually Inspect.	X	X
	Fan Turbine					
72-71-07	Packing Holders and		1	Visually Inspect.	X	X
	Seal Seats, Fan					
72-71-13	Manifolds, Rear Air		1	Visually Inspect.	X	X
	Bleed (Left and Right)					
72-71-15	Expansion Joint Liners,		1	Visually Inspect.	X	X
	Rear Bleed Manifold					
72-71-20	Fairings, Fan Discharge		1	Visually Inspect.	X	X
72-71-21	Fairings, Diffuser		1	Visually Inspect.	X	X
	Fan Duct					
72-71-22	Fairings, No. 4 Bearing		1	Visually Inspect.	X	X
	Tubes					
72-71-23	Fairing, Left Igniter Plug		1	Visually Inspect.	X	X

	ACCESSORIES					
ENGINE SECTION	DESCRIPTION	CHANGE NO.	ITEM	INSTRUCTIONS	ESV-1	
72-11-00	PT 7 Probe		1	Functional Check	X	
	Rear Retainer		2	Overhaul		
72-14-02	Fuel Pressure Switch		1	Bench Check	X	
72-37-01	Fuel Heater		1	Functional Check	X	
			2	Bench Check		
72-61-00	Oil Pressure Relief		1	Functional Check	X	
	Valve		2	Bench Check		
72-61-50	Oil Pump		1	Functional Check	X	
			2	Bench Check		
72-61-60	Oil Drain Valve		1	Functional Check	X	
			2	Overhaul		
73-11-10	Fuel Pump		1	Functional Check	X	
			2	Overhaul		
73-12-01	P &D Valve		1	Functional Check	X	
			2	Overhaul		
73-13-01	Fuel Nozzle		1	Bench Check	X	
	and Supports		2	Overhaul		
73-15-01	Fuel Manifold		1	Overhaul	X	

	ACCESSORIES					
ENGINE SECTION	DESCRIPTION	CHANGE NO.	ITEM	INSTRUCTIONS	ESV-1	
73-21-01	Fuel Control		1	Bench Check	X	
			2	Overhaul		
74-21-01	Ignition Exciter		1	Functional Check	X	
74-22-00	Spark Plugs		1	Replace	X	
75-22-01	Anti-ice Valve		1	Functional Check	X	
			2	Bench Check		
75-22-01	**Fuel Heater De-ice**		**1**	***Overhaul***	**X**	
	Valve		**2**	***Overhaul***		
75-30-00	Start Bleed Valve		1	Functional Check	X	
			2	Overhaul		
75-31-91	PRBC		1	Bench Check	X	
			2	Overhaul		
75-32-01	8th Stage Bleed Valve		1	Overhaul	X	
75-32-01	13th Stage Bleed Valve		1	Overhaul	X	
77-21-01	Thermocouples (8 ea.)		1	Functional Check	X	
			2	Bench Check		

	ACCESSORIES						
ENGINE SECTION	DESCRIPTION	CHANGE NO.	ITEM	INSTRUCTIONS	ESV-1		
77-22-01	Thermocouple Cable,		1	Functional Check	X		
	Front		2	Bench Check		X	
77-22-01	Thermocouple Cable,		1	Functional Check	X		
	Rear		2	Bench Check			
79-22-01	Fuel Oil Cooler		1	Bench Check	X		
			2	Overhaul			

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PRATT WHITNEY SERVICE BULLETINS
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SERVICE	ATA	SUBJECT/TITLE	AIR FORCE		NAVY		REMARKS	REVISION
BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
1464	72-36	Incorporation of Rear Compressor Alignment Pins		A		A		
1652	72-53	Incorporation of No. 4 1/2 and No. 6 Bearing Shield and Tube Assembly, Silver Plate on OD of Forward and Aft Supports		R		R	When required	
1705	73-15	Incorporation of Counterbored Recess in Fuel Manifold Assembly "Weep" Holes		A		A		
1717	72-38	Rework of Fan Diffuser Outer Duct Assembly		A		A		
1815	72-23	Provisions for Front Compressor (Installed) Trim Balancing Configuration	R	R	R	R		
1840	72-53	Rework of No. 4 1/2 and 6 Bearing Tube and Shield Assembly		R		R		
1883	72-71	Rework of Fan Exit Case Assembly and Compressor Case Assembly		R		R		
1954	72-53	Rework of No. 4 1/2 Bearing Retaining Nut		A		A		
1995	72-33 73-14	Replacement of Manifold and Support Attaching Tube Bolts and Washers. Repair of Anti-icing Manifold Assembly, Air Shutoff Valve Support Assembly, Air Shutoff Valves and Support Bracket Assemblies		A		A		
2016	72-00	Requirements for and Approval of Fuel and Additives	R	R	R	R		
2030	72-54	Provisions for Front Compressor Drive Turbine Assembly (Installed) Trim Balancing Configuration	R	R	R	R		

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SERVICE	ATA	SUBJECT/TITLE	AIR FORCE		NAVY		REMARKS	REVISION
BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
2135	72-33 72-52	Provisions for Balancing Front Compressor, Spacer Assembly, Compressor Rotor Assembly, Rear Compressor Drive Turbine and Turbine Rotor and Stator Assembly		A		A		
2139	72-61	Machining of Main Oil Pump Lockwire Clearance, Gearbox Rear Housing		R		R		
2141	72-23	Incorporation of Oil Dampenend No. 1 Bearing Configuration		A		A	If No. 1 bearing housing or major component scraps. Bearing replacement does not constitute attrition.	
2143	72-37	Rework of No. 4 Bearing Spanner Nut Key Washer		A		A		
2153	72-71	Rework of Front Bleed, Right Rear Bleed, and Left Rear Bleed Manifold Assembly		A		A		
2216	72-54	Rework of No. 4 1/2 Bearing Nozzle Assembly and Replacement of No. 6 Bearing Scavenge Oil Pump		R		R		
2225	72-54	Reinforcement of Shipping Mount Bolt Holes Fan Exhaust Outer Duct Assembly		A		A		
2240	72-54	Installation of No. 6 Oil Dampened Bearing	**A**	A	**A**	A		**1**
2244	72-71	Provisions for Field Replacement of Turbine Exhaust Duct and Fairing Assembly Retaining Parts		R		R		
2277	72-33	Rework of Replacement of 2nd and 3rd Stage Compressor Stator Assembly		A		A		
2338	72-61	Incorporation of Main Gearbox Tow Shaft Boss Pentagonal Seal		R		R		
2381	72-53	Rework of 3rd and 4th Stage Turbine Air Seal		A		A		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
2388	72-54	Replacement of Pt7 Tube Assembly	A	A	A	A		
2418	73-13	Rework of Fuel Nozzle		A		A		
2435	72-54	Shotpeening of Turbine Pressure Sensing Tube Assembly		A		A	Check SB 2388 for requirements	
2460	72-33	Rework of Front Compressor Tierods and Replacement of 6th Stage Compressor Disk, Blade, Blade Lock, and Shim		R		R	See SB 2923	
2520	73-31	Rework of Pressure Ratio Bleed Control Assembly		A		A		
2549	72-37	Replacement of No. 4 Bearing Oil Seal Ring Assembly Boss		A		A		
2560	72-41	Rework of Combustion Chamber Guide and Support		A		A		
2617	72-61	Replacement of Main Oil Strainer Cover Gearbox Nut	R	R	R	R		
2722	73-15	Provision for Separate Left and Right Primary and Secondary Fuel Manifold Assembly		A		A		
2732	72-37 72-41	Rework of Diffuser Case Assembly and Combustion Chamber Assembly. Replacement of Bracket Assembly and Bolts		A		A		
2754	73-15	Rework of Fuel Manifold Tube Attaching Loop Clamp Assembly		A		A		
2817	72-36	Investigation - Information Concerning Failure of 7th Stage Compressor Disk		M		M	AD 70-25-08	
2856	72-34	Incorporation of Compressor Case Assembly Vibration Damping Rubber Strip		R		R		
2923	72-33	Information Concerning 6th Stage Shimmed Blades		M		M	See SB 2460	
2927	72-61	Rework of Gearbox Drive Bearing Housing		R		R		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
2928	72-37 72-52	Rework of No. 4 and 5 Bearing Outer Heat Shield Assembly		R		R		
2929	72-34	Incorporation of Front Compressor No. 2 Bearing Breather Helical Configuration Tube with Provisions for Preloaded Clipping		R		R		
3103	72-71	Fuel Manifold Fairing Clamp Wear	M	M	M	M		
3104	72-37	Installation of Fuel Manifold Fairing Grommets	R	R	R	R		
3166	72-51	Replacement of Outer Duct Supports and Rework of Inner and Outer Combustion Chamber Duct and Support Assemblies		A		A		
3178	72-37	Incorporation of No. 4 Bearing Seal Air Filter		A		A	See SB 4180	
3183	72-54	Incorporation of Revised Attaching Configuration for Turbine Exhaust-To-Case Assembly, Turbine Exhaust Duct and Fairing Assembly		R		R	As required for repair	
3184	77-22	Rework of Thermocouple Cable and Function Box Assembly	A	A	A	A		
3226	72-38	Rework of Diffuser Fan Duct Strap and Fan Duct Assembly	R	R	R	R	Comply with if SB 4076 is incorporated and prior to incorporation of SB 2722	
3250	72-53	Rework of 3rd Stage Turbine Disk		A		A		
3264	72-33	Replacement of 2nd Stage Air Seal and Rework of 2nd Stage Compressor Stator Assembly and 3rd Stage Compressor Blades		A		A		
3275	72-61	Rework of Main Gearbox Assembly		A		A		
3285	72-33	Rework of 1st Stage Compressor Rotor Blade		A		A		
3287	72-34	Rework of No. 2 and 3 Bearing Nozzle Assembly		R		R		
3298	72-34	Rework of No. 3 Bearing Housing		A		A		

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SERVICE	ATA	SUBJECT/TITLE	AIR FORCE		NAVY		REMARKS	REVISION
BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
3309	72-33	Rework of 3rd and 4th Stage Compressor Stator Assembly		R		R		
3315	72-61	Repair of Gearbox Spur Starter Drive Gearshaft Assembly		A		A		
3346	72-34	Plugging of 6th Stage Compressor Disk Borescope Inspection Ports		R		R	Ref SB 1133	
3393	72-61	Replacement of Main Oil Filter (15 Micron)	R	R	R	R		
3472	72-36 72-37	Installation of 13th Stage Compressor Air Sealing Ring Assembly and Repair of 13th Stage Compressor Disk		A		A		
3505	72-36	Replacement of Rear Compressor Tierods		R		R		
3535	73-13	Information Concerning Fuel Nozzle Retaining Nut Assembly	M	M	M	M		
3536	73-13	Repair and Strengthening of Fuel Nozzle Support Assembly		M		M	AD 71-25-07/See SB 3866	
3549	72-36	Replacement of Rear Compressor Front Hub Seal Ring		A		A		
3566	72-23	Rework of No. 1 Bearing Housing Assembly		A		A	See SBs 3333 & 2141	
3580	72-33	Inspection of 1st Stage Fan Blades	M	M	M	M	AD 70-26-05/See 3285	
3588	72-37	Rework of Fuel Manifold Fairings		A		A		
3602	72-61	Replacement of Power Lever Cross Shaft Bearings		A		A		
3615	72-37	Rework of No. 4 and 5 Bearing Scavenge Pump Assembly		R		R	See SBs 1422 & 1509	
3699	72-33	Incorporation of Front Compressor Rotor Blade Adhesive	A	A	A	A	Refer to SB 3620	
3731	72-54	Inspection and Rework of No. 6 Bearing Scavenge Pump Bracket Assembly		A		A	See SB 3845	
3757	73-12	Plugging of Overboard Drain Port of Fuel Pressurizing and Dump Valve Assembly		A		A	Required with SB 4127	

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
3758	72-54	Rework of Pins and Bushings, Securing the Turbine Exhaust Duct and Fairing Assembly and No. 6 Bearing Oil Pressure Tube Assembly		A		A	See SB 3561	
3760	72-34	Incorporation of Bolted-on Compressor Case Assembly No. 3 Bearing Housing		A		A		
3808	72-33	Rework of Front Fan Case Assembly, 1st Stage Compressor and Stator Assembly		R		R	See SB 1547 and OHM	
3813	73-12	Calibration of Fuel Pressurizing and Dump Valve Assembly	R	R	R	R		
3845	72-54	Rework of No. 6 Bearing Scavenge Pump Assembly		R		R	See SBs 3932 & 4011	
3848	72-71	Rework of Rear Compressor Fan Duct Fairing Segment Assembly and Diffuser Fan Duct Fairing Assembly		A		A	See SB 5169	
3866	73-13	Rework of Fuel Nozzle and Support Assembly		R		R		
3908	72-38	Installation of No. 1 and 4 Bearing Oil Supply Chip Detection Equipment Tees		A		A		
3913	72-34	Replacement of the Internal No. 2 and 3 Bearing Pressure Tube Assembly		R		R		
3974	72-52	Replacement of No. 4 1/2 Bearing Seal Washer, Ring and Spacer		R		R		
4011	72-54	Rework of No. 6 Bearing Scavenge Pump Assembly		R		R	CW when SB 3845 incorp/See SB 4625	
4024	72-36	Information Concerning Cracked 7th Stage Compressor Disk	M	M	M	M	Accomplish when applicable P/N apply.	
4025	72-41	Rework of Inner Combustion Chamber Case Assembly		A		A		
4049	72-61	Repair of Gearbox Main Oil Strainer Cover		A		A		

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SERVICE BULLETINS	ATA NUMBER	SUBJECT/TITLE	AIR FORCE ESV-1	AIR FORCE ESV-2	NAVY ESV-1	NAVY ESV-2	REMARKS	REVISION NUMBER
4070	72-36	Rework of Rear Compressor Front Hub and Rear Compressor Sealing Tube		R		R		
4076	72-38	Replacement of Left and Right Fan Diffuser Duct Segment Assembly	R	R	R	R		
4101	**72-52**	**Incorporation of No. 5 Bearing Retaining Plate Screws**	**R**	**R**	**R**	**R**	**Applicable to engines with SB 3473**	**1**
4180	72-37	Replacement of No. 4 Bearing Seal Air Cleaner and Tubing	R	R	R	R	If SB 3822 not accomplished	
4183	72-41	Installation of Rear Compressor and Turbine Assembly Lugs and Bolts		A		A		
4187	72-53	Repair of Front Compressor Drive on Turbine Shaft		R		R	See SB 2550	
4193	72-33	Repair of Front Compressor Rear Hub		A		A	When Required/See AD 75-01-01	
4224	72-37	Replacement of No. 4 Bearing Oil Pressure Tube Elbow		R		R		
4232	72-33	Replacement of 5th Stage Compressor Rotor Disk Blades and Locks		R		R	See SB SB 4914/See SB 4232	
4239	72-36	Replacement of 8th and 9th Stage Compressor Blade Locks		R		R		
4247	72-00	Refurbishment or Repair of Main Ball Bearing		A		A		
4255	72-54	Replacement of No. 6 Bearing Seal, Spacer, Washer, and Ring		R		R	See SB 5578	
4295	72-61	Replacement of Oil Tank Mounting Washer		A		A		
4300	72-52	Rework of No. 5 Bearing Shield		R		R		
4313	73-13	Rework of Fuel Nozzle and Support Assembly		A		A		
4319	72-33	Rework of Compressor Rotor Spacer Assembly		A		A	See 4274	

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
4327	72-61	Repair of Main Oil Pump Assembly		A		A		
4330	72-53	Rework of 3rd Stage Turbine Rotor Blades		R		R		
4345	72-52	Rework of 1st Stage Turbine Blade		R		R		
4359	72-34	Incorporation of Bolted-on No. 2 Bearing Housing Assembly or Compressor Case Assembly		R		R	Comply with if seal removed	
4365	72-51	Rework of Combustion Chamber Duct Support Assembly		A		A		
4389	73-15	Fuel Manifold "B" Nuts for JT8D Engines	M	M	M	M	AD 75-05-06. Comply with when installing small "B" nut configuration. See SB 4484	
4420	72-36	Rework of 7th and 8th Stage Compressor Stator Assembly		A		A		
4421	72-41	Rework of Combustion Chamber Assembly Bushings, Pins, and Locks	R	R	R	R		
4423	**72-40**	**Convert pins at diffuser case from slat to straight**	**R**	**R**	**R**	**R**		**1**
4441	72-61	Replacement of Oil Tank Mount Strap Assembly		A		A	See SB 2895	
4451	72-41	Replacement of Diffuser Case to Outer Combustion Chamber Case Nuts		A		A		
4484	73-13 73-15	Incorporation of Improved Sealing Configuration to the Left and Right Primary and Secondary Fuel Nozzle and Support of Fuel Manifold Assembly	R	R	R	R	Applicable to SB 2722 only	
4505	72-23	Rework of No.1 Bearing Housing Cover		A		A	Refer to SB 2141	
4535	72-71	Rework of Combustion Chamber and Turbine Fan Duct Assembly		A		A	See SB 4127	
4538	72-41	Rework of Combustion Chamber Fuel Drain Manifold Assembly		A		A		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
4544	72-61	Replacement of Oil Tank Assembly Mount and Bracket		A		A	See SB 4441	
4547	72-37	Replacement of Rear Compressor and Turbine Assembly Bolts	A	A	A	A		
4561	72-41	Repair of Combustion Case Assembly		A		A		
4576	72-33	Rework of Compressor Rotor Spacer Assemblies		R		R		
4577	72-33	Inspection of 2nd Stage Fan Blade Pin Retention Rivets	M	M	M	M	AD 76-12-06	
4592	72-53	Modification of 3rd Stage Turbine Blade Riveting Configuration	M	M	M	M	AD 78-23-12	
4594	72-41	Information Concerning Crack Investigation and Inspection Requirements of Combustion Chamber Outer Case	M	M	M	M		
4597	72-34	Incorporation of 8th Stage Compressor Bleed System		R		R		
4615	72-53 72-61	Replacement of Preformed Packings at the Main Oil Pump and the No. 4-1/2 and 6 Bearing Shield and Tube Assembly Locations	R	R	R	R	Do not comply with during ESV-1, unless exposed.	
4625	72-54	Rework of No. 6 Bearing Scavenge Pump Bracket		A		A	Only if interference exists	
4637	72-53	Inspection and Reidentification of 4th stage Turbine Air Seal		R		R		
4369	72-53	Removal from Service of the No. 4-1/2 Bearing		M		M	AD 77-16-12	
4655	72-36	Replacement of 7th Stage Compressor Disk		A		A		
4662	72-53	Repair of 3rd Stage Turbine Disk		A		A		
4670	72-21	Rework of No. 1 Bearing Oil Nozzle	R	R	R	R	Comply with on Oil Dampened No. 1 Bearing Assembly (SB2141)	
4705	79-22	Rework of Fuel Flowmeter Adapter Inlet Tube Connector and Replacement of Oil Cooler Fuel Inlet Tube Connector		A		A		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
4706	72-34	Installation of Compressor Case Assembly		A		A		
4709	72-33	Rework of Compressor Counterweight		R		R	Comply with when installing SB 4576 counterweights	
4711	72-54	Improved Retention Features of the No. 4-1/2 and 6 Inner Bearing Oil Pressure Tube Assembly		A		A		
4714	72-33	Replacement of Front Compressor Rear Tierod and Nut	R	R	R	R	Comply with during ESV-1 if LPC is disassembled.	
4716	72-52 72-53	Rework of 1st, 2nd, 3rd, and 4th Stage Turbine Blades and 2nd, 3rd, and 4th Stage Turbine Vanes	R	R	R	R		
4723	72-36	Inspection of High Pressure Compressor Disk Tierod Hole Cracking		M		M	AD 81-08-02 superseded. AD 95016-07 applies.	
4725	72-36	Installation of 9th Thru 12th Stage Compressor Disk Bushings		A		A		
4744	72-53	Rework of 2nd Stage Turbine Stator	A	A	A	A	Comply with if repaired	
4780	72-61	Replacement of Gearbox Bearing Retaining Nut Key Washer	R	R	R	R		
4789	72-23	Replacement of No. 1 Bearing Support and Housing Assembly		A		A		
4792	72-37	Incorporation of Diffuser Case Assembly Ps4 Boss, Three-Inch Base		A		A		
4807	72-54	Rework of Bushing at the Turbine Exhaust Duct and Fairing Assembly and the Turbine Exhaust Case Boss		R		R	Refer to SB 3183	
4821	72-61	Rework of Fuel Pump Rear Coupling Retaining Bolts	R	R	R	R		
4824	72-36	Incorporation of 9th Stage Compressor Assembly Reinforcing Outer Ring		M		M		
4831	75-09	Modification of Air Shutoff Actuator and Valve		A		A		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
4837	72-37	Incorporation of No. 4 Bearing Housing Assembly Inner Heat Shield Standoff and Two-Piece Oil Pressure Elbow		A		A		
4838	73-13	Incorporation of Fuel Nozzle Ventilation Holes in Heat Shield	A	A	A	A		
4841	72-33	Inspection of 1st Stage Fan Hub Blade Slots	M	M	M	M	AD 78-17-02	
4849	72-53	Replacement of No. 4 1/2 Bearing Seal, Ring, and Washer		A		A		
4864	72-53 72-54	Rework of No. 6 Bearing Scavenge Pump Spur Gearshaft		A		A		
4866	72-34	Incorporation of No. 3 Bearing Baffle and Rework of Bearing Retaining Nut		R		R		
4871	73-13	Information Concerning Fuel Nozzle Metering Set Heat Shield		M		M		
4894	72-41	Replacement of Combustion Chamber Outer Case to Diffuser Case Bolts		A		A		
4913	72-53	Information Concerning 3rd Stage Turbine Disks Part Number Segregation		R		R		
4914	72-33	Incorporation of 3rd Through 6th Stage Compressor Blade Lock		R		R		
4916	72-23	Rework to Incorporate New Anti-icing Air Boss on Fan Inlet Case Assembly		A		A		
4924	72-37 72-52	Rework of No. 4 and 5 Bearing Inner Heat Shield Assembly and Replacement of No. 5 Bearing Pressure Tube Key Washer		A		A		

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SERVICE	ATA	SUBJECT/TITLE	AIR FORCE		NAVY		REMARKS	REVISION
BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
4927	72-21	Incorporation of Spring Tension Washers at Accessory Drive Gearbox Front Bearing Bushing Location		R		R		
4936	79-22	Rework of Fuel Flowmeter Adapter Connectors Bracket and Plate		A		A		
4937	75-09	Modification of Air Shutoff Anti-icing and Fuel Deicing Actuator and Valve		A		A		
4938	72-51 72-53	Reclassification of Turbine Air Seal Spacers	A	A	A	A		
4940	73-13	Inspection of Rework of Fuel Nozzle Throat Area Support Assembly	R	R	R	R		
4969	73-15	Increased Clearance and Improved "B" Nut Cushion Material for the Primary Configuration and Secondary Fuel Manifold Brackets and Clamps	A	A	A	A	Applies to "B" nut configuration	
4970	72-51	Reduced OD Combustion Chamber Duct Support Assembly	R	R	R	R		
4972	74-11	Ignition Exciter (Alternate A.C. Ignition System) Single Discharger Tube Circuit		A		A		
4977	72-51	Use of -15 Combustion Chamber Outlet Duct on -9A Engine		A		A		
4980	72-52	Incorporation of Honeycomb Seals in 1st Stage Turbine Air Seal		A		A	Refer to SB 4556	
4981	72-52	Honeycomb with Abradable Filler for 1st Stage Turbine Air Seal	A	A	A	A	Refer to SB 4980	
4982	73-21	Information Concerning Optional Use of Higher Rated Engine Model Fuel Controls on Lower Rated Engine Models	A	A	A	A		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
4995	72-42	Replacement of Combustion Chamber Spark Igniter Guide and Sleeve					Not required. Class 1A burners installed	
5021	**72-51**	**Improved 1st Stage Turbine Cooling**			**M**	**M**	**Re-introduced to fleet in 2003**	**1**
5027	72-71	Modification of Outer Exhaust Fan Duct Assembly to Provide an Access Port to the Inner No. 6 Bearing Oil Pressure Tube		R		R		
5032	72-54	Mod. of Pins/Guides & Bushings Used to Secure the Turbine Duct & Fairing Assy. & the #6 Bearing Oil Pressure Tube Assy. to the Turbine Exhaust Case Assy. Mod of Flange Bushing to Sleeve Bushing & Application of Coating PWA 257		R		R		
5039	73-13	Incorporation of Additional Air Holes in Air Curtain Heat Shield of Fuel Nozzle Assembly	R	R	R	R		
5044	73-21	JFC 60-1, -2 Fuel Control for Higher Acceleration Scheduled for Engines with 8th Stage Compressor Bleed Systems	R	R	R	R		
5065	72-37	Rework or Replacement and Stiffening of No. 4 Bearing Housing Diffuser Case Flange		A		A		
5070	72-37	Introduction of Universal Diffuser Case Assembly		A		A		
5084	72-33	Silicone Rubber Filling for 2nd Stage Compressor Stator Assembly at Outer Shroud		A		A		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
5107	72-53	Provisions for Extended Life of 2nd and 3rd Stage Turbine Disks and for the Usage of Certain Disks in Additional Engine Models		A		A		
5148	72-37	Repair of No. 4 Bearing Seal Ring Assembly that Exhibits Corrosion in the Heat Shield		A		A		
5150	72-38	Replacement of Diffuser Fan Right Duct Segment Assembly		A		A		
5154	72-36	Balance Flange Inspection and Rework of Rear Compressor Front Hub		M		M	AD 80-15-51	
5169	72-34 72-71	Incorporation of Stronger Braces and Additional Nut Plates for Rear Compressor Fan Duct Fairing Assembly and Diffuser Fan Duct		A		A		
5194	75-30	Inspection to Determine Hardness of the 8th and 13th Stage Bleed Valve Assembly		A		A		
5199	72-41	Improved Durability Configuration of Combustion Chamber Assembly		A		A		
5211	73-13	Incorporation of a (Racetrack) Seal Groove in the Base of the Support Assy to Accommodate a Hollow Metal Gasket for the Fuel Nozzle & Support Assembly		A		A		
5216	73-13	Configuration of Knife Edge Seal for Fuel Nozzle	R	R	R	R		
5223	73-13	Improved Durability and Sealing Capability of the Fuel Nozzle Support Gasket					Superseded by SB 6027 and SB 6032	
5226	72-36	Application of PWA 595 Coating on the 7th Thru Exit Stage of the Rear Compressor Stators		A		A		
5250	72-37	Incorporation of No. 4 Bearing Carbon Seal Assembly Configuration					Do not incorporate. Do not demodify. See SB 5447	

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
5253	72-71	Replacement or Modification of Turbine Exhaust Duct and Fairing Assembly to Provide for Trim Balance Access Port		A		A		
5328	72-37 72-52	Enlarged Bolt Holes and Spring Washers on No. 4 and 5 Bearing Heat Shield Assembly		A		A		
5331	72-53	Modification of the 3rd Stage Turbine Blade for Increased Shroud Notch Contact Area and Undersize Air Sealing Ring Modification	A	A	A	A	Comply with if 75% or more blades not serviceable/AD 97-19-14	
5333	72-61	Incorporation of Sealant Retention Grooves in Main Gearbox Main Oil Pump Cavity Liner		A		A		
5339	72-37	Modification of Diffuser Case Plug		A		A		
5340	72-37	Incorporation of Positive Retention Lug for No. 4 Bearing Overboard Vent Bushing to Diffuser Case Boss		A		A		
5348	72-51	Replacement of Turbine Stator Front Flange Support Assembly	A	A	A	A	See SB 5289	
5350	72-53	Incorporation of 2nd Stage Compressor Stator Assembly Recambered Vanes		A		A		
5371	72-33	Incorporation of PWA74-1 Nickel Graphite Abradable Rubstrip Coating for Front and Rear Fan Case		A		A		
5373	72-23	Replacement of Inner Shroud of the Fan Inlet Case Assembly		A		A	SBs 1738 & 5350 mandatory with this SB	
5375	72-53	Reduction of Rotor Seal Clearance and Gaspath Leakage to Improve Performance of the Low Pressure Turbine		A		A	See SB 5733	
5380	72-33	Incorporation of Vanes with Revised Airfoil Contour and Improved Aerodynamic Efficiency for 1st Stage Compressor Stator Assembly	R	R	R	R		

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SERVICE	ATA	SUBJECT/TITLE	AIR FORCE		NAVY		REMARKS	REVISION
BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
5385	72-53	Incorporation of Improved Sulfidation Protection for 2nd Stage Turbine Vanes				A		
5390	73-15	Incorporation of Bolted on Fairings for Fuel Manifold Supply Tube Assembly		A		A	Prior to SB 2722	
5395	75-32	Incorporation of Extended Valve Skirt for 8th and 13th Stage Bleed Valve Assembly		R		R		
5397	72-52	Replacement of No.5 Bearing Pressure Tube Key Washer		A		A		
5407	72-33	Shotpeening and Anti-galling Treatment for Front Compressor Rear Tierod		A		A	See SB 4714	
5409	72-33	Increase Snap Diameters for Compressor Rotor Spacer Assemblies on 3rd/4th and 4th/5th Stage Spacers		R		R	Comply with if snap requires repair/See SB 5716	
5411	72-52	Various Repairs for the Honeycomb Air Sealing Turbine Ring Assembly		A		A		
5413	72-33	Replacement of 2nd Stage Compressor Stator Assembly Inner Seal Ring Blind Rivets with solid Rivets		A		A	Comply with if loose or missing	
5414	72-37	Modification to Improve 13th Stage Stator Durability		A		A		
5420	72-36	Removal of Rear Compressor Hub or Hub Assembly Counterweight Flange and Incorporation of Separate Counerweight Support		A		A		
5422	73-21	Common Calibration Schedule for JFC 60-1, Fuel Control for use on JT8D-7, -7, -9, -11 and -15 Model Engines		A		A		
5434	72-53	Revised PWA 5732 Material for 2nd Stage Turbine Vanes		A		A	Applies to SB 5107 STD only	

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
5439	72-36	Replacement of 13th Stage Compressor Disk		A		A		
5449	72-34	Condensation Drain Hole for No. 2 Bearing Housing Heat Shield		A		A		
5481	72-53	Incorporation of Aluminum Silicon Coating for 3rd and 4th Stage Turbine Blades		A		A		
5483	72-71	Replacement of Three-Piece Fiberglass Fairings with Two-Piece Metal Fairings for Diffuser Fan Duct Fairing Assembly		A		A		
5490	72-37	Replacement of Diffuser Fan Duct Bracket Assembly	R	R	R	R		
5491	72-53	Replacement of 4th Stage Turbine Rotor Hub with Two-piece Configuration		A		A		
5494	72-53	Removal from Service No. 4 1/2 Bearing	R	R	R	R	Applies to JT8D-9A engines obtained by conversion per SB 3800 and SB 4129, except engines incorporation ASB 4639/Ref SB 5603	
5499	72-53	Modification of 2nd Stage Turbine Air Seal Ring Assembly, Stator Lock, and Damper Area		A		A	See SB 5375	
5506	72-52	Incorporation of PWA 270 Variable Thickness Over PWA 273 Coating, 1st Stage Turbine Blades		A		A		
5510	72-53	Inspection and Repair 2nd Stage Turbine Disk and Modification of Front Snap Diameters 3rd Stage Low Pressure Turbine Air Seal	A	A	A	A	See AD 85-19-51	
5514	72-41	Replacement No. 4 1/2 and 5 Bearing Scavenge Tube Assy., No. 4 & 5 Bearing Heat Shield Assy., and No. 5 Bearing Oil Pressure Nozzle Bolt		A		A		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
5518	72-34 72-37	Replacement of 13th Stage High Pressure Compressor Ring Assembly Configured with Threaded Bolt Holes		A		A		
5519	72-71	Turbine Sound Absorbing Liner Segment - Incorporating PWA 53-2 Coating		A		A		
5527	72-34 72-61	Modification of Bearing Retaining Nut and Gearbox Bevel Drive Gear		R		R	See SB 5905	
5543	72-33	2nd Stage Compressor Stator Assy Modification		R		R	Comply with if assembly requires repair	
5553	72-53	Rivet and Washer - 2nd and 4th Stage Turbine Blade Retention		R		R	Applies to SB 5107 standard only	
5555	72-53	4th Stage Turbine Airseal Modification		R		R	Applies to SB 5107 disk only	
5557	72-33	Front Compressor Rear Hub Assembly Tierod Hole Bushing Repair		R		R	Comply with if assembly requires repair	
5560	72-34	Removal of Plugs from 8th Stage Hub Assembly		A		A	As required to obtain -9A configuration	
5561	72-51	1st Stage Turbine Vane Assembly Modification		A		A		
5562	**72-53**	**4th Stage Turbine Airseal Replacement**	**R**	**R**	**R**	**R**		**1**
5571	75-31	PRBC Repair Helical Coil Insert Required in the PS4 Ports		A		A	If repair required	
5573	72-52	Modification of No. 5 Bearing Seal Assembly	M	M	M	M	See SB 5708	
5577	72-53	Low Turbine Shaft Inspection and Repair		M		M		
5578	72-54	No. 6 Bearing Front Sealing Modification		A		A		
5579	72-37	No. 4 Bearing Strainer Assembly Replacement With a Metering Plug		A		A	SB 5250 only	
5589	74-22	Information concerning the use of JT9D Engine Igniter Plugs in JT8D engines		R		R		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
5592	74-21	Replacement of Exciter Cables with either Bendix or Simmonds		A		A		
5631	72-41	Replacement of No. 5 Bearing Housing Assy. and No. 4 and 5 Bearing Inner Heat Shield Gaskets		A		A	Superceded by SPB P1839 inc in build paper NRR	
5639	72-41	Inspection of Combustion Chambers	M	M	M	M	AD 86-09-02/AD86-82-52	
5643	72-52	Modification to #5 Bearing Seal Assy by Adding Oil Deflector, Heatshield, Ring Holder and Springs	R	R	R	R		
5649	72-36	Replacement of Removable Sleeve Spacer with Integral Sleeve Spacer		M		M	AD 86-08-04	
5674	73-14	Replacement of Fuel Heater Manifold Lower Support			R	R	Accomplish as per Part 1, Replacement of Air Shut Off Valve Bracket Assembly	
5676	72-41	Inspection of Outer Combustion Chamber Case	M	M	M	M	AD 87-11-07/Superceded by SB 6228	
5708	72-37	Replacement of #4 and #5 Bearing Seal Rings	R	R	R	R		
5709	72-37	Modification No. 4 Bearing Heat Shield Assy to Incorporate an Antirotation Feature		A		A	Applies to SB 5250 only???	
5716	72-1301	Incorporation of a reduced front inner snap diameter spacer assembly					See SBs 5734 and 6429	
5718	72-61	Replacement of Main Gearbox Assy Face Seal and Seal Option	R	R	R	R	During ESV-1, replace external carbon seals only.	
5729	72-33	Second Stage Fan Blade Root Inspection	M	M	M	M	AD 87-14-01	
5734	**72-33**	**No. 4 spacer reduced front & inner increased outer snap diameters**	**R**	**R**	**R**	**R**		**1**
5758	72-33	Eddy Current Inspection of 1st Stage Fan Blades	R	R	R	R		

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5767	72-53	Removal of Outer Lug on 2nd Stage Turbine Disk Rear Face	R	R	A	A		
5776	72-52	Rework of Rear Compressor Drive Turbine Shaft Oil and Lock Pin Holes		R		R		
5792	72-61	Replacement of Gearbox Main Oil Pump Bearing		R		A		
5800	72-53	Incorporation of Improved Rear Turbine Anti-rotation Pins		A		A		
5801	72-71	Magnesium Zirconate Coat Combustion Chamber Outer and Inner Ducts	R	R	R	R		
5814	72-61	Replacement of CSD Gearshaft Front and Rear Key Washers & Bearing Retaining Nuts		R		A		
5822	72-53	Removal of #4 1/2 Bearing from Service	R	R	R	R	AD 77-16-12	
5841	72-33	Incorporation of 1st Stage Fan Blade Retaining Plate	M	M	M	M	AD 89-25-11/SPB P 1989	
5858	72-53	Replacement of 2nd and 3rd Stage Turbine Stator Locks		R		A		
5866	72-33	Replacement of 2nd Stage Compressor Disk and Blades		A		A		
5872	**75-10**	**Replacement of Left and Right Anti-Icing Tube Assemblies and Revised Clamping Locations**	**A**	**A**	**A**	**A**		**1**
5900	72-41	Inspection Requirements of No. 4 and No. 5 Bearing Heat Shield Assembly		R		R		
5905	72-34	Incorporation of No. 3 Bearing Stainless Steel Spacer Assembly with Anti-rotation Pins		R		A		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
5913	72-53	Inspection of 3rd & 4th Stage Turbine Blades for Crossnotch Wear	M	M	M	M	AD 92-10-05	
5927	72-34	Incorporation of New Grommet and Clamps for No. 2 Bearing Breather Tube Assembly		A		A		
5945	72-52	Incorporation of an Improved Oil Return and Compartment Sealing Configuration for No. 5 Bearing Seal Assy.	R	R	R	R		
5946	72-33	Incorporation of Recontoured Leading Edge 1st Stage Fan Blades	A	A	A	A		
5952	**72-34**	**Replacement of Left and right Anti-Icing Tube Assemblies**	**A**	**A**	**A**	**A**		**1**
5966	72-41	Replacement of Outer Combustion Chamber Case	A	A	A	A		
5975	72-36	HPC rear hub spline root crack removal	R	R	R	R		**1**
5989	72-37	Incorporation of Oil Return Holes and Improved Compartment Sealing of No. 4 Bearing Seal Assembly		R		R	Comply with if SB 5250 previously incorporated	
6000	72-00	Incorporation of Non-Asbestos Loop Clamps, Gaskets, Packings, and Strips		A		A		
6011	72-33	Replacement of Compressor 2nd Stage Thrust Washers and Blades	A	A	A	A		
6014	**72-36**	**Hub Assembly, Rear, High Pressure Compressor (HPC)-with Improved Oil Scavenge Functions**	**R**	**M**	**R**	**M**		**1**
6027	73-13	Replacement of Fuel Nozzle Support to Diffuser Case Gasket	R	R	A	A		
6032	73-13	Availability of Fuel Nozzle Support to Diffuser Case Gasket	R	R	A	A	Comply with if SB 5211 previously incorporated	
6034	73-13	Inspection and Replacement of Fuel Nozzle and Support Assembly	R	R	R	R		
6047	72-41	Inspection Requirements for No. 4 and No. 5 Bearing Heat Shield Assemblies	R	R	R	R		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
6078	72-51	Incorporate More Durable High Pressure Turbine Gasket	A	A	A	A		
6093	72-61	Replacement of Oil Pressure Relief Valve Spring	A	A	A	A		
6110	72-53 72-54	Improved 3rd & 4th Stage Low Pressure Turbine Containment	M	M	M	M	AD 94-20-08. For ESV-1, if rotor does not require disassembly, installation of #3 seal ring may be deferred until ESV-2.	
6114	72-36	Use of 7th, 8th, & 9th Stage Compressor Blades Using New Manufacturing Methods		A		A		
6119	72-51	Incorporation of Larger Combustion Chamber Duct Assembly Rivets	A	A	A	A		
6131	72-54	Modification of No. 6 Bearing Scavenge Pump to Allow LPT Intermeshing of Blades and Vanes if an LPT Shaft Fracture Occurs	M	M	M	M	AD 94-20-08	
6142	72-33	Modification or Replacement of Low Pressure Compressor Front Hub to Improve Low Cycle Fatigue Characteristics	A	A	A	A		
6147	72-33	Modification to Ensure Sufficient Clearance Between Anti-ice Tube Brackets and Weld on Fan Inlet Case	R	R	R	R	If inadequate clearance exists due to weld repairSee SB 6166	
6152	72-61	Inspection for Cracks in the Gearbox Constant Speed Drive Spur Gear		R		R		
6158	73-21	Engine-Plug, Condensation Trap, Modification of to Increase Drain Hole Size	R	R	R	R	If not Previously Complied With (PCW).	
6164	72-53	Incorporation of Improved No. 6 Bearing Seal with Improved Wear Characteristics	M	M	A	A		
6166	72-33	Incorporation of Stronger Bolts and Redesigned Brackets for Front Anti-ice Tubes	A	A	A	A		

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
6180	**72-09,72-37,72-38**	**Modification to Install Fire Resistant Fittings**	**M**	**M**	**M**	**M**		**1**
A6196	72-52	Seal, assembly, No. 5 Bearing-Incorporation of an Improved Oil Return and Compartment Sealing Configuration	M	M	M	M		
6199	72-37	Replacement of No. 4 Bearing Internal Drain, Air Supply and Internal (Pressure and Scavenge) Seals	A	A	A	A		
6200	72-37	Replacement of No. 4 Bearing Internal Breather Tube Assembly Seal	A	A	A	A		
6202	72-41	Inspection of Combustion Chamber Outer Case for Integranular Cracks	M	M	M	M	If OCC Case disassembled.	
6223	72-61	Gearshaft and Coupling, Constant Speed Drive and Gearshaft, Starter Drive-Introduction of Gearshaft with Mechanically attached Coupling Bolts	A	A	A	A		
A6228	72-41	Case Assembly, Combustion Chamber Outer (Original Design)-Consolidated Inspection Requirements	R	R	R	R	AD 96-23-14	
6230	72-41	Case Assembly, Combustion Chamber Outer ("EB Welded" Design)- Consolidated Inspection Requirements	R	R	R	R	See AD 94-25-07	
6237	**72-36**	**Blade, High Pressure Compressor (HPC) 7th Stage- Provide a new 7th Stage Blade with a thicker Leading Edge**	**A**	**A**	**A**	**A**		**1**
6246	**74-21**	**Cables, Exciter-Replacement of; To provide a more durable cable**	**A**	**A**	**A**	**A**		**1**

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6256	**72-34**	**Support, No.3 Bearing- Introduction of a more durable support without a Heat Shield for repair of Compressor Intermediate Cases**	**R**	**M**	**R**	**M**		**1**
6261	72-14	Engine-Clamps, Loop, Fuel Deice Tubes-Inspection and Replacement of Clamps with Vendor Codes 6087	R	R	R	R	If not PCW.	
6262	72-54	Engine-Clamps, Loop, Turbine Exhaust Pressure Tubes-Inspection and Replacement of Clamps with Vendor Codes 6087	R	R	R	R	If not PCW.	
6266	72-53	Engine- Blade, 2nd, 3rd, and 4th Stage Low Pressure Turbine (LPT) Rotor-Remove Blades Made From Cobalt Material (AMS 5382)	A	A	R	R	ESV#1 If LPT debladed	
6267	72-53	Engine-No. 4 ½ Bearing-Provide a new Option Number and an Additional Source for the No. 4 ½ Bearing	A	A	A	A		
6274	72-53	Engine- Hub, 4th Stage Low Pressure Turbine (LPT)-Inspection for Cracks	M	M	M	M	ESV#1 If T-4 hub debladed	
6278	73-13	Engine Fuel Control-Fuel Nozzle and Support Assembly-Provide a more durable Fuel Nozzle Heat Shield	A	A	A	A		
6282	75-10	Air-Spacer, Airframe Bracket-Add Spacer for Clearance	R	R	R	R	If not PCW.	
6316	**72-52**	**Eddy current inspection of the No.5 bearing Carbon Seal Assembly(Post ASB 6196)**	**R**	**R**	**R**	**R**		**1**
6336	**72-30**	**Replace 2nd stage defective compressor disk**	**M**	**M**	**M**	**M**		**1**

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BULLETINS	NUMBER		ESV-1	ESV-2	ESV-1	ESV-2		NUMBER
6348	72-09	Replace primary and secondary fuel manifolds with one having steel nuts	A	R	A	R		1
6350	73-23	New No. 1 bearing seal housing increase fit with pins	R	R	R	R		1
6355	72-53	Replace LPT garlock seal with one made out of improved material	R	R	R	R		1
6370	72-53	No. 4 1/2-6 oil tube and shield packing replacement	A	A				1
6371	72-61	New reusuable greabox split line seal	R	M	R	M		1
6381	73-11	Fuel pump control shaft wear inspection	M	M	M	M		1
6390	72-36	C8 through C112 disk corrosion inspection due to a problem with the application of PWA 110-21	R	M	R	M		1
6401	72-34	New No. 3 bearing spacer of bevel gear which incorporates two pins.	R	R	R	R		1
6424	72-61	Replacement of of main oil filter cover packing						1
6426	72-00	7th through 12th stage disk Ni-Cad plating	R	R	R	R	Required if disk stripped	1
6429	72-30	Replacement or modification of 2nd stage spacer assembly and LPC tierod.					AD 2003-05-07	1
6431	72-30	HPC corrosion inspection		M		M		1
6439	73-00	Eng Fuel and Control, Fuel Pump Duel Element Gear, Replacement or Modification of.		M		M		1

SERVICE BULLETINS	ATA NUMBER	SUBJECT/TITLE	AIR FORCE ESV-1	AIR FORCE ESV-2	NAVY ESV-1	NAVY ESV-2	REMARKS	REVISION NUMBER
1264	72-53	Replacement of turbine stator vanes and turbine stator inner shroud assembly, 2nd, 3rd and 4th stages.					Obsolete	
1577	72-33	Incorporation of turbine front and intermediate one-piece case assembly.					Obsolete	
1628	**72-51**	**Rework of No. 5 bearing pressure tube assembly.**		**A**		**A**	**Obsolete**	1
1632	**72-54**	**Replacement of No. 6 bearing housing pin assembly.**		**A**		**A**	**Obsolete**	1
1636	72-51	Replacement of combustion chamber rear support assembly.					Obsolete	
1648	72-52	Replacement of turbine shaft coupling lock.					Obsolete	
1649	72-52	Inspection and reidientification of 5th stage compressor disk.					Obsolete	
1657	72-38	Replacement of diffuser fan duct sealing seat attaching bolts.					Obsolete	
1664	**72-61**	**Replacement of oil pump drive bevel gearshaft.**		**A**		**A**	**Obsolete**	1
1678	72-36	Rework of rear compressor 10th stage disks and blades.					Obsolete	
1679	**72-36**	**Rework of rear compressor drive turbine spacer.**		**A**		**A**	**Obsolete**	1
1684	72-36	Rework of rear compressor tierods.					Obsolete	
1687	**72-61**	**Rework of gearbox bracket assembly.**		**A**		**A**	**Obsolete**	1
1705	**73-15**	**Incorporation of counterbored recess in fuel manifold assembly "weep holes."**		**A**		**A**	**Obsolete**	1
1713	**75-31**	**Replacement of pressure ratio bleed control assembly shaft and bearings.**		**A**		**A**	**Obsolete**	1
1721	72-33	Rework of 3rd and 4th stage compressor stator assemblies.					Superceded by SB 3309	
1724	**72-61**	**Rework of pressure relief valve assembly.**		**A**		**A**	**Obsolete**	1
1736	**72-51**	**Replacement of 1st stage turbine vane inner retention bolts.**		**A**		**A**	**Obsolete**	1

SERVICE BULLETINS	ATA NUMBER	SUBJECT/TITLE	AIR FORCE ESV-1	AIR FORCE ESV-2	NAVY ESV-1	NAVY ESV-2	REMARKS	REVISION NUMBER
1738	72-23	Rework of No. 1 bearing and housing support assembly.		A		A	Superceded by overhaul manual 23-02/23-03	
1747	72-51	Incorporation of thicker front flange, combustion inner case, thicker rear flange, combustion chamber support assembly and relocated rear flange turbine stator support assembly.					Obsolete	
1758	**73-13**	**Replacement of fuel nozzle support gasket.**		**A**		**A**	**Obsolete**	1
1767	**72-54**	**Rework of Pt7 right internal tube assembly.**		**A**		**A**	**Obsolete**	1
1782	**72-37**	**Replacement of front snap diameter, nickel/tungsten carbide hardface, compressor exit stage stator assembly.**		**A**		**A**	**Obsolete**	1
1793	**72-34**	**Rework of fuel de-icing tube loop clamp bracket**		**A**		**A**	**Obsolete**	1
1800	**72-61**	**Replacement of gearbox drive gearshaft bearings**		**R**		**R**	**Superceded by SBs 2111/3440**	1
1807	**72-37**	**Rework of No. 4 and 5 bearing shield assembly**					**Superceded by SB 4374**	1
1818	**72-61**	**Replacement of gearbox bearing tube connector attaching extension stud and bolt.**		**A**		**A**	**Obsolete**	1
1819	**72-61**	**Rework of gearbox front housing assembly bracket assembly.**		**A**		**A**	**Obsolete**	1
1831	**72-71**	**Replacement of fan exhaust duct segment fastening screws and washers.**		**A**		**A**	**Obsolete**	1
1839	79-22	Rework of oil cooler fuel inlet tube connector					Superceded by SB 4705	
1891	**72-61**	**Rework of oil pressure relief valve assembly.**		**A**		**A**	**Obsolete**	1
1907	72-37	Replacement of compressor exit stage stator assembly, air sealing ring assembly and attaching bolts.					Obsolete	

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			ESV-1	ESV-2	ESV-1	ESV-2		
1913	**72-37**	**Replacement of No. 4 bearing housing oil and air tube coupling nuts.**		**A**		**A**	**Obsolete**	1
1919	72-36	Rework of rear compressor sealing tube					Obsolete	
1924	72-61	Modification of gearbox starter drive and de-oiler drive seal configuration.					Obsolete	
1963	**72-52**	**Replacement of No. 5 bearing**		**A**		**A**	**Obsolete**	1
1965	**72-61**	**Inspection of inner and outer power lever cross shaft.**		**A**		**A**	**Obsolete**	1
1966	**72-37**	**Replacement or rework of No. 4 bearing.**		**A**		**A**	**Obsolete**	1
1980	**72-53**	**Rework of 2nd stage turbine disk.**		**A**		**A**	**Obsolete**	1
1986	**72-34 72-61**	**Rework of gearbox drive bevel gearshaft and replacement of No. 2 and No. 3 bearing nozzle assembly.**		**A**		**A**	**Obsolete**	1
1995	**72-33 73-14**	**Replacement of manifold and support attaching tube bolts and washers. Repair of anti-icing manifold assembly, air shut-off valve support assembly, air shut-off valves and support bracket assemblies.**		**A**		**A**	**Obsolete**	1
2022	**72-61**	**Rework of gearbox rear housing assembly.**		**A**		**A**	**Obsolete**	1
2031	**72-34**	**Rework of compressor case assembly.**		**R**		**R**	**Obsolete**	1
2032	**72-36**	**Replacement of 7th stage blade rivet rear compressor rotor and stator assembly.**		**A**		**A**	**Obsolete**	1
2048	**72-54**	**Rework or replacement of No. 6 bearing inner pressure tube assembly and turbine exhaust dust fairing assembly.**		**A**		**A**	**Obsolete**	1
2067	**72-37**	**Rework of No. 4 bearing oil and air tubes.**		**A**		**A**	**Obsolete**	1

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2068	**72-51**	**Replacement of combustion chamber support assembly and rework of duct inner assembly and duct outer assembly.**					**Superceded by SB 2378**	1
2074	**72-71**	**Replacement of fan exhaust duct assembly.**		**A**		**A**	**Obsolete**	1
2089	72-61	Incorporation of main oil strainer 40 micron mesh oil straining element					Superceded BY SB 3393	
2115	72-37	Replacement of mounting flang No. 4 bearing housing assembly					Superceded by SB 4837	
2128	**72-34**	**Rework of No. 2 bearing elbow**		**A**		**A**	**Obsolete**	1
2129	72-33/72-36	Blending of compressor disk dovetail slots					Obsolete	
2131	**72-38**	**Incorporation of diffuser fan duct fairing trailing edge pin safety wire sealant silicone**	**R**	**R**	**R**	**R**	**Superceded by SBs 3258/5483**	1
2182	**73-14**	**Incorporation of fuel heater assembly pickings.**		**A**		**A**	**Obsolete**	1
2194	**72-61**	**Replacement of gearbox front bracket assembly**		**A**		**A**	**Obsolete**	1
2200	**72-00**	**Information concerning seals, O-Rings, and pickings**	**A**	**A**	**A**	**A**	**Obsolete**	1
2201	**73-12**	**Calibration of fuel pressurizing and dump valve assembly**		**A**		**A**	**Obsolete**	1
2224	**72-37**	**Rework of No. 4 bearing housing**		**A**		**A**	**Obsolete**	1
2227	**72-41**	**Incorporation of combustion chamber assembly deflector**		**A**		**A**	**Obsolete**	1
2254	**72-61**	**Rework of gearbox rear housing assembly**		**A**		**A**	**Obsolete**	1
2260	72-33	Rework of 6th stage compressor rotor blade and dovetail shim. Addition of blade lock.					Obsolete	
2268	**72-00**	**Rework of bleed control diaphragm support clevis assembly**		**A**		**A**	**Obsolete**	1
2274	**72-41**	**Additional welding of combustion chamber front liner deflector.**	**A**	**A**	**A**	**A**	**Superceded BY SB 2531**	1

SERVICE BULLETINS	ATA NUMBER	SUBJECT/TITLE	AIR FORCE ESV-1	AIR FORCE ESV-2	NAVY ESV-1	NAVY ESV-2	REMARKS	REVISION NUMBER
2343	**72-61**	**Replacement of oil pressure relief valve plug.**		**A**		**A**	**Obsolete**	1
2347	**72-53**	**Rework of No. 4 1/2 heat shield assembly.**		**A**		**A**	**Superceded by SB 5945**	1
2371	72-61	Rework of oil pump bevel gearshaft.					Obsolete	
2378	**72-41**	**Replacement of outer duct assembly, rework combustion chamber support and replace the inner duct assembly and inner rear supports.**		**R**		**R**	**Obsolete**	1
2389	**72-54**	**Rework of No. 4 1/2 and 6 bearing tube and shield assemblies.**		**A**		**A**	**Obsolete**	1
2408	**72-54**	**Modification of turbine bearing scavenge pump assembly.**		**R**		**R**	**Superceded by SB 3845**	1
2411	**72-37**	**Rework of No. 4 bearing breather outer internal manifold assembly.**		**A**		**A**	**Obsolete**	1
2418	**73-13**	**Rework of fuel nozzles.**		**A**		**A**	**Obsolete**	1
2436	**72-41**	**Rework of combustion chamber liner.**		**A**		**A**	**Obsolete**	1
2452	**72-53**	**Repair of front compressor drive turbine shaft.**	**M**	**M**	**M**	**M**	**Superceded by SB 2550/See AD 75-01-01**	1
2528	**72-33**	**Replacement of oil coller front mounting bracket.**		**A**		**A**	**Superceded by SB 3008**	1
2531	**72-41**	**Incorporation of reduced smoke emission configuration combustion chamber assembly.**	**R**	**R**	**R**	**R**	**Obsolete**	1
2550	**72-53**	**Replacement of front compressor drive turbine shaft and rework of turbine shaft and coupling.**		**A**		**A**	**Obsolete**	1
2626	72-33	Replacement Of 3rd stage compressor blade locks and rework of 3rd stage compressor disk.					Obsolete	
2627	**72-52**	**Replacement of 1st stage turbine air seal and rework of 1st stage turbine blade.**		**R**		**R**	**Superceded by SB 4161**	1
2659	**72-53**	**Replacement of 2nd, 3rd, and 4th stage turbine air sealing rings.**					**Obsolete**	1
2660	**72-61**	**Incorporation of fuel control quick disconnect retaining bolt locks.**		**A**		**A**	**Obsolete**	1

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			ESV-1	ESV-2	ESV-1	ESV-2		
2669	**72-34**	**Rework of No. 2 bearing retaining nut key washer.**		**A**		**A**	**Obsolete**	1
2672	**72-51**	**Rework of combustion chamber support assembly and combustion chamber inner duct assembly.**		**A**		**A**	**Obsolete**	1
2684	**72-41**	**Replacement of combustion chamber igniter guide and sleeve.**		**A**		**A**	**Superceded by SB 4995**	1
2711	**72-34**	**Rework of front compressor fan duct plug bracket.**		**A**		**A**	**Obsolete**	1
2712	**72`-55**	**Rework of turbine fan duct segment assembly.**		**A**		**A**	**Obsolete**	1
2721	**72-53**	**Rework of second stage turbine vane and turbine air seal spacers.**		**R**		**R**	**Superceded by SB 4744**	1
2728	**72-34**	**Reinforcement of flange front compressor fan duct.**		**A**		**A**	**Superceded by SB 4366**	1
2751	**72-23**	**Rework of inlet case positioning plate and inlet case tube connector assembly**		**A**		**A**	**Obsolete**	1
2755	72-41	Rework of combustion chamber support reinforcing plate.					Obsolete	
2770	**72-54**	**Information concerning No. 6 scavenge pump bracket assembly design (steel).**		**M**		**M**	**Superceded by SB 3845**	1
2806	**75-32**	**Rework of bleed valve and cover.**	**R**	**R**	**R**	**R**	**Superceded by SB 5395**	1
2812	72-41	Rework of combustion chamber pins.					Obsolete	
2853	72-38	Rework of diffuser fan duct strap and fan duct assembly.					Obsolete	
2888	**72-61**	**Rework of oil supply tube and fuel pump drive gearshaft.**		**A**		**A**	**Obsolete**	1
2892	**72-52**	**Information concerning 1st stage turbine blades.**	**R**	**R**	**R**	**R**	**Superceded by SB 3162**	1
2912	**72-41**	**Plasma coating of fuel nozzle nuts, interconnector tubes, and combustion chamber.**		**A**		**A**	**Obsolete**	1

SERVICE BULLETINS	ATA NUMBER	SUBJECT/TITLE	AIR FORCE ESV-1	AIR FORCE ESV-2	NAVY ESV-1	NAVY ESV-2	REMARKS	REVISION NUMBER
2914	**72-53**	**Provide a repair procedure for 2nd stage turbine stator shroud with replaceable inner front knife-edge air seal.**		**A**		**A**	**Obsolete**	1
2923	**72-33**	**Information concerning 6th stage shimmed blades.**		**M**		**M**	**Superceded by SB**	1
2952	72-36	Provisions for scalloped counterweight flange 7th stage disk.					Obsolete	
2997	**72-53**	**Additional spacer classes front compressor drive turbine shaft spacer.**		**A**		**A**	**Obsolete**	1
3004	**72-33**	**Rework of front compressor rear hub.**					**Superceded by SPB P0266/do in conjunction with SB 2461.**	1
3060	**75-32**	**Rework of compressor bleed valve assembly.**		**A**		**A**	**Obsolete**	1
3098	**72-34**	**Incorporation of bolted-on No. 2 bearing housing, compressor case assembly.**		**A**		**A**	**Obsolete**	1
3106	72-33	Rework of compressor blade plate and compressor blade lock.					Obsolete	
3121	**72-37**	**Repair of diffuser case assembly.**		**A**		**A**	**Obsolete**	1
3132	**72-61**	**Incorporation of gearbox rear housing oil strainer stud staking pin.**		**A**		**A**	**Obsolete**	1
3133	**72-54**	**Rework of No.6 bearing housing.**		**A**		**A**	**Obsolete**	1
3194	**73-13**	**Information concerning fuel nozzle metering set heat shield.**	**M**	**M**	**M**	**M**	**Obsolete**	1
3217	**73-21**	**Replacement of No. 4 bearing internal tube assembly and thrust wire assembly.**		**A**		**A**	**Obsolete**	1
3258	**72-71**	**Rework of left and right diffuser fan duct fairing.**		**A**		**A**	**Obsolete**	1
3333	**72-23**	**Rework No. 1 bearing housing assembly.**		**A**		**A**	**Obsolete**	1
3399	**72-71**	**Removal of fairing assembly right igniter plug and fairing assembly left igniter plug.**		**A**		**A**	**Superceded by SB 5169**	1

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3404	**72-61**	**Removal of CSD gearbox spur gearshaft assembly and rework of CSD gearshaft coupling.**		**A**		**A**	**Obsolete**	1
3444	**72-34**	**Information concerning front compressor fan duct plug.**		**A**		**A**	**Obsolete**	1
3473	**72-41**	**Installation of oil dampened configuration for No. 5 bearing assembly.**		**A**		**A**	**Obsolete**	1
3538	**72-54**	**Rework of No. 6 bearing inner internal pressure tube assembly and guide.**		**R**		**R**	**Superceded by SB 4711**	1
3543	**72-53**	**Rework of front compressor drive turbine shaft.**		**A**		**A**	**Obsolete**	1
3553	**72-36**	**Incorporation of integral 8th stage disk and hub on rear compressor rotor.**		**A**		**A**	**Obsolete**	1
3620	**72-33**	**Rework of plate and spacer assembly and replacement of front compressor front hub.**		**A**		**A**	**Obsolete**	1
3651	72-33	Information concerning 5th stage compressor rotor disk blades.					Obsolete	
3674	**72-61**	**Repair of oil tank cap assembly.**		**A**		**A**	**Obsolete**	1
3731	**72-54**	**Inspection and rework of No. 6 bearing scavenge pump bracket assembly.**		**A**		**A**	**Superceded by SB 3845**	1
3739	**72-37**	**Installation of diffuser case jack screw hole plugs.**		**A**		**A**	**Obsolete**	1
3800	**72-00**	**Conversion of JT8D-7A to -9A model**		**A**		**A**	**Obsolete**	1
3810	**72-61**	**Replacement of gearbox rear housing mount lug bushings (right angle).**		**A**		**A**	**Obsolete**	1
3822	72-37	Replacement of No. 4 bearing seal air cleaner.		A		A	Superceded by SB 4180	
3838	**72-38**	**Rework of fan diffuser outer duct assembly.**		**A**		**A**	**Obsolete**	1

SERVICE BULLETINS	ATA NUMBER	SUBJECT/TITLE	AIR FORCE		NAVY		REMARKS	REVISION NUMBER
			ESV-1	ESV-2	ESV-1	ESV-2		
3848	72-71	Rework of rear compressor fan duct fairing segment assembly and diffuser fan duct fairing assembly.		A		A	Superceded by SB 5169	1
3912	72-41	Replacement of outer combustion chamber case assembly and combustion chamber turbine fan duct assembly.		A		A	Obsolete	1
3932	72-54	Rework of No. 6 bearing scavenge pump assembly.		R		R	Superceded by SB 3845	1
3977	72-33	Rework of front compressor rotor and stator spacer assembly.		A		A	Obsolete	1
4012	72-41	Rework of combustion chamber and/or liner assembly.		A		A	Obsolete	1
4024	72-36	Information concerning cracked 7th stage compressor disk.	M	M	M	M	Applicable P/N 484907, 500507, 695607, 698307, 699307, 699707, 701407, 701507	1
4040	72-52	Rework of 1st stage turbine blade.		A		A	Obsolete	1
4098	72-52	Rework of No. 5 bearing assembly housing and replacement of No. 5 bearing assembly damper.		A		A	Obsolete	1
4119	72-37	Rework of no. 4 bearing internal tube assembly and replacement of preformed packing.		A		A	Obsolete	1
4129	72-00	Information concerning redesignation of JT8D-9 to JT8D-9A.		R		R	Obsolete	1
4137	72-61	Rework of gearbox drive coupling and replacement of coupling retaining ring.		A		A	Obsolete	1
4147	72-61	Rework of gearbox screen strainer element assembly.		A		A	Obsolete	1
4148	72-36	Modification of rear compressor rotor and stator assembly.		A		A	Superceded by SB 4603	1
4151	72-53	Information concerning No. 2 hub and low turbine shaft inspection.	M	M	M	M	Superceded by SB 4290	1
4161	72-51	Repair of 1st stage turbine air seals with knife edge wear.					Obsolete	1

SERVICE BULLETINS	ATA NUMBER	SUBJECT/TITLE	AIR FORCE ESV-1	AIR FORCE ESV-2	NAVY ESV-1	NAVY ESV-2	REMARKS	REVISION NUMBER
4165	72-33	Rework of front compressor rotor and stator assembly and front fan case assembly.		A		A	Obsolete	1
4190	72-41	Rework of combustion chamber assembly.		A		A	Obsolete	1
4226	72-33	Rework of front compressor front hub and 1st stage blades.	R	R	R	R	Superceded by overhaul manual.	1
4229	72-33	Repair of front compressor rear hub.		A		A	Superceded by SPB P0026	1
4232	72-33	Replacement of 5th stage compressor rotor disk blades and locks.		R		R	Superceded by SB 4914	1
4244	72-54	Incorporation of clearance slots for turbine fan duct segment assembly and inner front fan exhaust duct segment assembly.		A		A	Superceded by SB 6039	1
4284	72-36	Incorporation of the 9th stage compressor stator assembly reinforcing outer ring.					Obsolete	
4290	72-33	Rework of front compressor rear hub.		R		R	Superceded by SPB P0266	1
4317	72-33	Replacement of 2nd stage compressor disk and blades.					Obsolete	1
4348	72-34	Replacement of 8th stage compressor disk and rework of 7th/8th and 8th/9th compressor rotor spacers.		A		A	Obsolete	1
4350	72-33	Replacement of 3rd stage compressor rotor blade.		A		A	Obsolete	1
4366	72-34	Replacement of front compressor fan duct assembly.		A		A	Obsolete	1
4369	72-33	Incorporation of 3rd stage compressor stator assembly rivets.		A		A	Obsolete	1
4374	72-37/72-52	Rework of No. 4 and 5 bearing outer assembly heat shield.		A		A	Obsolete	1
4379	72-54	Modification of No. 6 bearing housing		A		A	Obsolete	1
4383	72-61	Incorporation of gearbox drive bevel gear oil drain holes.		A		A	Obsolete	1
4389	73-15	Fuel manifold "B" nuts for JT8D engines.	M	M	M	M	Superceded by SB 4486	1
4433	72-53	Rework of t3rd stage turbine disk.		A		A	Superceded by SB 4592	1

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4483	72-36	Replacement of 12th stage compressor disk and rework of 11th/12th and 12th/13th stage compressor rotor spacers.					Superceded by SB 4935	1
4535	72-71	Rework of combustion chamber and turbine fan duct assembly.		A		A	Superceded by SB 4127	1
4555	72-33	Replacement of 2nd stage compressor rotor blade retaining pin, rivet and bushing.	M	M	M	M	Superceded by SB 4577	1
4556	72-51	Replacement of 1st stage turbine air seal.		A		A	Superceded by SB 4161	1
4594	72-41	Information concerning crack investigation and inspection requirements of combustion chamber outer case.	M	M	M	M	Superceded by SB 5542	1
4603	72-36	Replacement or modification of the 7th stage compressor disk.					Superceded by SB 4655	1
4662	72-53	Repair of 3rd stage turbine disk.		A		A	Obsolete	1
4705	79-22	Rework of fuel flow meter adapter inlet tube connector and replacement of oil cooler fuel inlet tube connector.		A		A	Superceded by SB 4936	
4714	72-33	Replacement of front compressor rear tierod and nut.	R	R	R	R	Superceded by SB 4939/5407	1
4723	72-36	Inspection of HPC disk tierod hole cracking.		M		M	Superceded by SB 4935/AD 95-16-07	1
4725	72-36	Installation of 9th-12th stage compressor disk bushings.		A		A	Superceded by SB 4935	1
4744	72-53	Rework of 2nd stage turbine stator.	A	A	A	A	Superceded by SB 2721	1
4837	72-37	Incorporation of No. 4 bearing housing assembly inner heat shield standoff and two-piece oil pressure elbow.		A		A	Superceded by SB 2115	1
4841	72-33	Inspection of 1st stage fan hub blade slots	M	M	M	M	Superceded by SB 4910/AD 78-17-02	1
4843	73-14	Replacement of fuel filter differential pressure warning switch assembly.		A		A	Obsolete	1

SERVICE BULLETINS	ATA NUMBER	SUBJECT/TITLE	AIR FORCE ESV-1	AIR FORCE ESV-2	NAVY ESV-1	NAVY ESV-2	REMARKS	REVISION NUMBER
4899	**72-34**	**Rework of No. 3 bearing, gearbox drive bevel and spacer and No. 3 bearing seal.**					**Superceded by SB 2170/5527**	1
4910	72-33	Replacement of front compressor front hub.					Obsolete	
4911	72-61	Replacement of main gearbox accessory drive face seals.					Superceded by SB 5718	
4914	**72-33**	**Incorporation of 3rd -6th compressor blade locks.**		**R**		**R**	**Superceded by SB 4232**	1
5187	**72-36**	**Incorporation of 7-8, 8-9 stage compressor integral sleeve type spacers**					**Superceded by SB 5649/AD 86-08-04**	1
5223	73-13	Improved durability and sealing capability of the fuel nozzle support gasket.					Superceded by SB 6027/6032	
5289	**72-51**	**Incorporation of large undercut fillet radius on front flange of turbine stator support assembly.**		**A**		**A**	**Superceded by 5348**	1
5313	**72-51**	**Information concerning 1st stage turbine vane baffle assembly.**		**A**		**A**	**Superceded by SB 5516**	1
5410	**72-00**	**Performance improvement percentages obtained through incorporation of specific SB**		**A**		**A**	**Obsolete**	1
5426	**72-51**	**Revised baffle cooling air pattern for 1st stage turbine vane assembly.**		**A**		**A**	**Superceded by SB 5561/Refer to SB 5021**	1
5447	**72-37**	**Incorporation of narrow lip of No. 4 and 5 bearing seal assembly and expanded usage of No. 5 oil dampened bearing seal assembly.**	**A**	**A**	**A**	**A**	**Superceded by SB 5714**	1
5483	**72-71**	**Replacement of 3 piece fiberglass fairing with 2 piece medal fairings for diffuser fan duct fairing assembly.**		**A**		**A**	**Superceded by SB 3258**	1
5517	**72-33**	**Replacement of 1st stage low pressure compressor blade retaining plates, compressor counterweights and tierod key washers.**					**Superceded by SB 5739**	1
5542	**72-41**	**Case assembly, combustion chamber outer inspection requirements.**	**R**	**R**	**R**	**R**	**Superceded by ASB 5676**	1

PRATT WHITNEY SERVICE BULLETINS
NUMERICAL LISTING
INACTIVE

SERVICE BULLETINS	ATA NUMBER	SUBJECT/TITLE	AIR FORCE ESV-1	AIR FORCE ESV-2	NAVY ESV-1	NAVY ESV-2	REMARKS	REVISION NUMBER
5546	**72-52**	**Modification and installation of No. 5 bearing shield**	**R**	**R**	**R**	**R**	**Superceded by SB 5643**	1
5631	**72-41**	**Replacement of No. 5 bearing housing assembly and No. 4 and 5 bearing inner heat shield gaskets**		**A**		**A**	**Superceded by SPB P 1839**	1
5662	**72-41**	**Incorporation of combustion chamber assembly, PWA 253-1, 254-1, 261 or magnesium zirconate coating an 2nd through 11th liner inner surface.**	**R**	**R**			**Superceded by SB 5461**	1
5676	**72-41**	**Inspection of outer combustion chamber case.**	**M**	**M**	**M**	**M**	**Superceded by SB 6228/AD 87-11-07**	1
5697	72-53	Improved containment of 4th stage low pressure turbine.					Superceded by SB 6039/6110	
5733	**72-53**	**Replacement of 2nd and 3rd stage turbine air sealing ring and 2nd stage LPT damper assembly.**		**R**		**A**	**Superceded by ASB 6110**	1
5858	**72-53**	**Replacement of 2nd and 3rd stage turbine stator locks.**		**A**		**A**	**Obsolete**	1
6015	**72-36**	**Replacement of No. 6 bearing seal.**		**A**		**A**	**Obsolete**	1
6038	**72-53**	**Inspection of 7-12 compressor disks for corrosion.**		**M**		**M**	**Superceded by ASB 6431/AD 98-12-07**	1
6097	**72-61**	**Modification of gearbox rear housing to reduce oil leaks.**	**R**	**R**	**A**	**A**	**Superceded by SB 6371**	1
6124	**72-41**	**Inspection of combustion chamber outer case assembly.**	**M**	**M**	**M**	**M**	**Superceded by ASB 6230**	1
6126	**72-34**	**No. 3 bearing support used for repair of compressor intermediate case.**		**R**		**A**	Air Force: If in immediate area which allows incorporation. **Superceded by SB 6256**	1
6148	**72-41**	**Inspection of outer combustion chamber case assembly.**	**R**	**R**	**R**	**R**	**Superceded by ASB 6228/SB 6230.**	1
6318	**72-36**	**HPC disk coating (PWA 110-21)**	**R**	**R**	**R**	**R**	**Removed from Spec because P & W now states that Ni-Cad plating better protects metals than the sermetal coating.**	**1**

AUTHORIZED DER REPAIRS

E.O. #	REV	DESCRIPTION	C-9N	C-9A	T-43	C-9M
7221-01	A	Front Accessory Housing Cracked and Broken Bolt Hold Weld Repair.	Pending	Pending	Pending	Pending
7234-13	Original	Bevel Gear ID Flame Plate Repair.	Approved	Approved	Pending	Approved
7234-14	A	Bevel Gear # 3 Bearing Journal Chromium Plate.	Approved	Approved	Pending	Approved
7236-12	Original	Plating Rear Compressor Rotor Tube Seal Lands.	Approved	Approved	Pending	Approved
7236-15	Original	C7 and C8 Disk Replacement (Insitu).	Pending	Pending	Pending	Pending
7237-06	Original	13th Stage Ring Assembly Bolt Hole Weld Repair.	Pending	Pending	Pending	Pending
7241-12	B	#4 and #5 Outer Heat Shield Weld and Plasma Repair-Forward Edge.	Pending	Approved	Pending	Pending
7241-16	Original	Weld Repair (Worn 4/5 Bearing Heat Shield Assy).	Approved	Pending	Pending	Approved
7260-08	A	Main Accessory gear Box Cover-Main Gear Box Support Face.	Approved	Approved	Pending	Approved
7260-09	Original	De-Oiler Carbon Seal Bore-repair.	Approved	Pending	Pending	Approved
7261-15	Original	N2 Gear Box Oil Pump Liner-Jack Screw Location retainer Screws.	Approved	Approved	Pending	Approved